

	<u>Parameters:</u>		
<b>Diameter:</b>	.045"	1/16"	.035"
<b>Current:</b>	DCRP	DCRP	DCRP
<b>Amperage:</b>	150-250	175-350	90-150
<b>Voltage:</b>	22-26	24-28	17-22
<b>Wire Extension:</b>	1/2" -3/4"	1/2" -1"	1/2" -3/4"
<b>Shielding Gas:</b>	Mix gas	Mix gas	Mix gas

**Description:**

Weldamatic 969-G is gas-shielded, general purpose hardfacing alloy and can be used for metal-metal and metal-earth friction application. It is often used in applications mining parts, agricultural tillage tools, and dredge components. Weldamatic 969-G uses DC straight or reverse polarity. It has no machinability, grinding only, no surface checks, good impact resistance and abrasive resistance.

**Contains:** carbon, silicon, molybdenum, chromium, manganese

**Hardness as deposited (2 layers):** 55-60

**Two to 3 layers recommended.**

Shielding Gas: 98% Ar, 2% O<sub>2</sub> or 100% CO<sub>2</sub> or 75% Ar, 25% CO<sub>2</sub>

**Chemical Composition:**

C	Mn	Si	Cr	Ni	Fe
0.6	1.6	1.5	6.6	0.7	BAL

**Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.**

**CAUTION:** Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.