

**Parameters:**

<b>Diameter:</b>	.045"	1/16"
<b>Current:</b>	DCRP	DCRP
<b>Amperage:</b>	150-200	175-350
<b>Voltage:</b>	21-28	24-28
<b>Wire Extension:</b>	1/2"-3/4"	1/2"-1"
<b>Shielding gas:</b>	Open arc wire or CO <sub>2</sub>	Open arc wire or CO <sub>2</sub>

**Description:**

Weldamatic R-101 is self-shielding and can be used in applications that require abrasion resistance. It is often used in applications of blades, cutter, tillage tools, conveyor screws etc. Weldamatic R-101 uses DC straight or reverse polarity. It has no machinability, grinding only, excellent cross checks, good abrasion resistance, moderate impact strength and a hot wear service of 1100°F. Hardness as deposited (2 layers) is 58-62 with 2 to 3 layers recommended.

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

Shielding gas: 75% Ar, 25% CO<sub>2</sub> or 100% CO<sub>2</sub>

**Chemical Composition:**

C	Mn	Si	Cr	Others	Fe
5.5	1.0	0.8	18.3	0.3	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 CRF 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.