



# Tube-Alloy 242-O

## TYPICAL MECHANICAL PROPERTIES (AS WELDED):

- **ABRASION RESISTANCE:** Good
- **IMPACT RESISTANCE:** Good
- **MACHINABLE**
- **CUTTING:** Can be oxy-fuel (flame) cut
- **Magnetic**

## RECOMMENDED OPERATING PARAMETERS:

Diameter		Polarity	Stick-Out		Optimum Amps	Volts	Deposition Rate	
Inches	MM		Inches	MM			Amps	Lbs./Hr
1/16	1.6	DCEP	1"-1.5"	25-38	225-275	23-25	200	6
					<b>275-350</b>	<b>24-27</b>	250	10
					350-400	26-29	300	14

Start with **middle ranges** and adjust accordingly. Higher amperages will increase deposition rate, dilution, and heat input to base metal. Increasing voltage will widen and flatten bead profile, but excessive voltage will result in porosity. Too much electrical stickout may result in increased spatter, and too little may result in internal porosity.

## AVAILABLE DIAMETERS AND PACKAGES:

Diameter		33-lb. Spool
Inches	mm	
1/16	1.6	S604219-029

## APPLICATIONS:

- Carbon Steel Frogs
- Carbon Steel Rolls
- Crane Wheels
- Idlers
- Rail Ends
- Steel Shafts
- Switch points
- Tractor Rollers

**TECHNICAL QUESTIONS?** For technical support of Hobart Filler Metals products, contact the Applications Engineering department by phone toll-free at 1-800-532-2618 or by e-mail at [Applications.Engineering@HobartBrothers.com](mailto:Applications.Engineering@HobartBrothers.com)

### CAUTION:

Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 St, Miami, FL 33166-6672 (can also be downloaded online at [www.aws.org](http://www.aws.org)); OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210

Safety Data Sheets on any Hobart Brothers LLC product may be obtained from Hobart Customer Service or at [www.hobartbrothers.com](http://www.hobartbrothers.com).

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