

## PRODUCT OVERVIEW

**POLYVAN O**—is an iron based metal cored wire, designed to produce weld deposits containing vanadium tungsten carbides. These carbides form during solidification of the weld puddle, and are evenly dispersed throughout a tough austenitic matrix. POLYVAN O wear resistance is higher than that of chromium carbide but less than tungsten carbide. POLYVAN O can be applied in multiple layers and on applications up to 900°F. Deposits are not machineable and cannot be flame cut.

## TYPICAL DEPOSIT CHARACTERISTICS:

- ⇒ Abrasion Resistance: Excellent
- ⇒ Impact Resistance: Moderate-High
- ⇒ Deposit Layers: Multiple
- ⇒ Deposit Cross Checks: No
- ⇒ Magnetic: Yes
- ⇒ Hot wear hardness: 900° F
- ⇒ Machineability: No

## SPECIFICATION:

Vanadium and tungsten carbides in an austenitic matrix

## APPLICATION

- ⇒ Shovel bucket tooth adapters
- ⇒ Shovel bucket sides and lips
- ⇒ Dozer end bits
- ⇒ Crushing and grinding equipment
- ⇒ Conveyor screws
- ⇒ Stabilizers
- ⇒ Debarking and tub grinder hammers
- ⇒ Pug mill knives

## NOMINAL CHEMICAL COMPOSITION (wt%)

V	W	C	Si	Mo	Fe
16.0	6.0	3.9	1.4	0.4	Bal

## RECOMMENDED GTAW PARAMETERS:

Diameter	Current	Voltage	Amperage	Shielding Gas	Wire Extension	Position
.062" (1.6mm)	DCEP	22-26	150-200	None or CO2	1/2" - 3/4"	Flat

The properties listed are typical and not to be construed as guaranteed values. Actual properties may vary depending on customer operating conditions.

## STANDARD SIZES & PACKAGING:

Diameter	Packaging
.062" (1.6mm)	25# lws