

## PRODUCT OVERVIEW

**POLYCHROME 100 C**—an iron based high chromium carbide metal cored wire, designed for metal to earth applications with severe abrasion and light to moderate impact. POLYCHROME 100C develops a fine cross check pattern and is used for a wide range of applications in the crushing, grinding and construction industry. A unique attribute of POLYCHROME 100C is that it can be applied in multiple layers using stringer beads and special procedures (contact Polymet for more information). This process is used to refurbish coal and cement pulverizer rolls and rings. Deposits are normally limited to two layers, and cannot be machined or flame cut.

### TYPICAL DEPOSIT CHARACTERISTICS:

⇒ Abrasion Resistance:	Good
⇒ Impact Resistance:	Moderate
⇒ Hardness:	HRC 58-62
⇒ Deposit Layers:	*2 Passes
⇒ Deposit Cross Checks:	Yes
⇒ Magnetic:	Yes
⇒ Hot wear hardness:	900°F
⇒ Machineability:	No

\*Multi-layer when applied using stringer beads and automatic operations. Limited applications, contact Polymet for more information

### SPECIFICATION:

Chrome carbide

## APPLICATION

- ⇒ Shovel bucket tooth adapters, sides & lips
- ⇒ Crushing and grinding equipment
- ⇒ Pulverizer rolls and rings
- ⇒ Cage mill pins & disc
- ⇒ Wear plate, pipe & elbows

## NOMINAL CHEMICAL COMPOSITION (wt%)

Cr	C	Mn	Mo	Si	Fe
25.0	4.5	2.0	1.0	1.0	Bal

## RECOMMENDED GTAW PARAMETERS:

Diameter	Current	Voltage	Amperage	Shielding Gas	Wire Extension	Position
.109" (2.8mm)	DCEP	26-30	275-600	None	3/4"-1 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
.109" (2.8mm)	60# coil, 220# drum, 500#drum