

## PRODUCT OVERVIEW

**POLYTIC O**—is an iron based metal cored wire designed to produce weld deposits containing evenly dispersed titanium carbides, in a martensitic matrix. POLYTIC O exhibits excellent abrasion resistance, while maintaining toughness and impact resistance. It is best suited in applications with high stress and abrasion. POLYTIC O can be applied crack free, with proper procedures. Deposits are not machineable and can not be flame cut.

### TYPICAL DEPOSIT CHARACTERISTICS:

- ⇒ Abrasion Resistance                      Good
- ⇒ Impact Resistance:                      Good
- ⇒ Deposit Layers:                              3 passes
- ⇒ Deposit Cross Checks:                    \*No
- ⇒ Magnetic                                      Yes
- ⇒ Machineability                              No

\*Crack free deposit require control of preheat and interpass temperatures

### SPECIFICATION:

Titanium carbide in a martensitic matrix

## APPLICATION

- ⇒ High pressure cement clicker rolls
- ⇒ Shovel bucket sides & lips
- ⇒ Dozer end bits
- ⇒ Crushing and grinding equipment
- ⇒ Hammer crushers
- ⇒ Stabilizers
- ⇒ Debarking and tub grinder hammers

## NOMINAL CHEMICAL COMPOSITION (wt%)

Cr	Ti	C	Mn	Mo	Si	Fe
8.0	6.0	2.0	1.5	1.5	0.8	Bal

## RECOMMENDED GTAW PARAMETERS:

Diameter	Current	Voltage	Amperage	Shielding Gas	Position
.062" (1.6mm)	DCEP	21-25	225-275	None	Flat
.109" (2.8mm)	DCEP	29-32	450-550	None	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
.109" (2.8mm)	60# coil