

## PRODUCT OVERVIEW

**POLYCHROME 100**—an iron based high chromium carbide metal cored wire, designed for metal to metal earth applications with severe abrasion and light to moderate impact. POLYCHROME 100 develops a fine cross check pattern and is used for a wide range of applications in the crushing, grinding and construction industry. Deposits are normally limited to two layers. Deposits cannot be machined or flame cut.

### TYPICAL DEPOSIT CHARACTERISTICS:

⇒ Abrasion Resistance:	Good
⇒ Impact Resistance:	Low—moderate
⇒ Hardness:	HRC 55-60
⇒ Deposit Layers:	2 Passes
⇒ Deposit Cross Checks:	Yes
⇒ Magnetic:	Yes
⇒ Hot wear hardness:	900°F
⇒ Machineability:	No

### SPECIFICATION:

High chrome carbide alloy

## APPLICATION

- ⇒ Shovel bucket tooth adapters
- ⇒ Shovel bucket sides & lips
- ⇒ Crushing and grinding equipment
- ⇒ Conveyor screws
- ⇒ Fan blades
- ⇒ Hardface plate & pipe

## NOMINAL CHEMICAL COMPOSITION (wt%)

<b>Cr</b>	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>Fe</b>
23.0	5.0	2.0	1.0	Bal

## RECOMMENDED GTAW PARAMETERS:

Diameter	Current	Voltage	Amperage	Shielding Gas	Wire Extension	Position
.045" (1.2mm)	DCEP	22-26	150-200	98%Ar2%O2	1/2"-3/4"	Flat & horizontal
.062" (1.6mm)	DCEP	24-28	200-260	None or CO2	1/2" - 1"	Flat & horizontal

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
.045" (1.2mm)	33# lws
.062" (1.6mm)	33# lws