**POLYTUNG NiCrBWC**—is a nickel chrome boron silicon matrix system, with 38-44% tungsten carbide particles. This combination produces a superior microstructure when welded and has excellent fine particle erosion, corrosion and toughness. The low heat input when welding POLYTUNG NiCrBWC reduces the amount of tungsten carbide particles going into solution. Deposits are not machinable and cannot be flame cut.

### TYPICAL DEPOSIT CHARACTERISTICS:
- Abrasion Resistance: Excellent
- Impact Resistance: Moderate—high
- Deposit Layers: 1-3 passes
- Deposit Cross Checks: Yes
- Magnetic: Yes
- Hot Wear Hardness: 900° F
- Machineability: No

### APPLICATION
- Dredge cutter teeth & heads
- Rotary bucket dredge teeth
- Dozer end bits
- Pipe & elbow ID slurry type application
- Conveyor screws
- Stabilizers
- Filter screens

### NOMINAL CHEMICAL COMPOSITION (wt%)

<table>
<thead>
<tr>
<th>W</th>
<th>Cr</th>
<th>Si</th>
<th>B</th>
<th>Ni</th>
</tr>
</thead>
<tbody>
<tr>
<td>38-44</td>
<td>10.0</td>
<td>2.2</td>
<td>1.0</td>
<td>Bal</td>
</tr>
</tbody>
</table>

### RECOMMENDED WELDING PARAMETERS:

<table>
<thead>
<tr>
<th>Diameter</th>
<th>Current</th>
<th>Voltage</th>
<th>Amperage</th>
<th>Shielding Gas</th>
<th>Wire Extension</th>
<th>Position</th>
</tr>
</thead>
<tbody>
<tr>
<td>.062” (1.6mm)</td>
<td>DCEP</td>
<td>17-22*</td>
<td>90-150</td>
<td>75Ar25Co2</td>
<td>3/4” - 1”</td>
<td>Flat</td>
</tr>
</tbody>
</table>

⇒ Use lowest possible heat input for best results

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:

<table>
<thead>
<tr>
<th>Diameter</th>
<th>Packaging</th>
</tr>
</thead>
<tbody>
<tr>
<td>.062” (1.6mm)</td>
<td>25# LWS</td>
</tr>
</tbody>
</table>