POLYTUNG O— is a self shielding hardfacing wire with tungsten carbide particles in a high hardness iron matrix that provides excellent wear resistance for earth engaging tools and other high wear applications.

**TYPICAL DEPOSIT CHARACTERISTICS:**

- Abrasion Resistance: Excellent
- Impact Resistance: Moderate
- Deposit Layers: 1
- Deposit Cross Checks: Yes
- Magnetic: Yes
- Hot wear hardness: 900° F
- Machineability: No

**APPLICATION**

- Cultivator chisels
- Tillage tools
- Dozer end bits
- Grain hammers
- Conveyor screws
- Stabilizers
- Filter screens

**NOMINAL CHEMICAL COMPOSITION (wt%)**

<table>
<thead>
<tr>
<th>W</th>
<th>Si</th>
<th>C</th>
<th>Fe</th>
</tr>
</thead>
<tbody>
<tr>
<td>38-44</td>
<td>2.0</td>
<td>2.0</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>*90-120</td>
<td>None</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# coil</td>
</tr>
</tbody>
</table>

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E-mail: sales@polymet.us