

PRODUCT OVERVIEW

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

SPECIFICATION:

Tungsten carbide particles in an iron matrix

APPLICATION

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

NOMINAL CHEMICAL COMPOSITION (wt%)

W	Si	C	Fe
38-44	2.0	2.0	Bal

RECOMMENDED WELDING PARAMETERS:

Diameter	Current	Voltage	Amperage	Shielding Gas	Wire Extension	Position
.062" (1.6mm)	DCEP	*17-22	*90-120	None	3/4" - 1"	Flat

*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:

Diameter	Packaging
.062" (1.6mm)	25# coil