PRODUCT OVERVIEW

POLYVAN O—is an iron based metal cored wire, designed to produce weld deposits containing vanadium tungsten carbides. These carbides form during solidification of the weld puddle, and are evenly dispersed throughout a tough austenitic matrix. POLYVAN O wear resistance is higher than that of chromium carbide but less than tungsten carbide. POLYVAN O can be applied in multiple layers and on applications up to 900°F. Deposits are not machineable and cannot be flame cut.

TYPICAL DEPOSIT CHARACTERISTICS:

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

APPLICATION

- Shovel bucket tooth adapters
- Shovel bucket sides and lips
- Dozer end bits
- Crushing and grinding equipment
- Conveyor screws
- Stabilizers
- Debarking and tub grinder hammers
- Pug mill knives

NOMINAL CHEMICAL COMPOSITION (wt%)

<table>
<thead>
<tr>
<th>V</th>
<th>W</th>
<th>C</th>
<th>Si</th>
<th>Mo</th>
<th>Fe</th>
</tr>
</thead>
<tbody>
<tr>
<td>16.0</td>
<td>6.0</td>
<td>3.9</td>
<td>1.4</td>
<td>0.4</td>
<td>Bal</td>
</tr>
</tbody>
</table>

RECOMMENDED GTAW 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>22-26</td>
<td>150-200</td>
<td>None or CO2</td>
<td>1/2” - 3/4”</td>
<td>Flat</td>
</tr>
</tbody>
</table>

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>