

POLYWEAR 60 GMAW

Gas Metal Arc Welding

February, 2024

PRODUCT OVERVIEW

POLYWEAR 60—nickel chrome silicon boron metal cored wire that forms complex borides and carbides in a nickel matrix. POLYWEAR 60 is designed for a wide range of applications, such as: metal to metal sliding, metal to earth high abrasion, and a combination of wear, corrosion, oxidation or galling. Deposits maintain a high level of hardness up to 1200°F. POLYWEAR 60 yields smooth deposits and can be applied to low and medium carbon steels, cast iron, and stainless steels.

TYPICAL DEPOSIT CHARACTERISTICS:

⇒ Abrasion Resistance	Excellent
⇒ Impact Resistance:	Moderate
⇒ Corrosion Resistance:	Good
⇒ Hardness:	* HRC 55-60
⇒ Deposit Layers:	2 maximum
⇒ Machineability:	Grind
⇒ Hot hardness:	up to 1200°F
⇒ Surface Cross Check:	Yes
⇒ Machineability:	Grind only

SPECIFICATION:

APPLICATION

- ⇒ Draw blocks
- ⇒ Impeller screws
- ⇒ Slurry pipe and elbows
- ⇒ Oil extrusion screws
- ⇒ Sewage extrusion screws

NOMINAL CHEMICAL COMPOSITION (wt%)

B	C	Cr	e	Si	Ni
3.5	0.7	15.0	4.3	4.3	BAL

RECOMMENDED GTAW PARAMETERS:

Diameter	Current	Voltage	Amperage	Shielding Gas	Position
.062" (1.6mm)	DCEP	24-26	200-240	Argon	Flat

The properties listed are typical and not to be construed as guaranteed values. Actual properties may vary depending on customer operating conditions.

STANDARD SIZES:

Diameter

.062" (1.6mm)