

VertiWear® 600

GAS-SHIELDED HARD SURFACING WIRE

Overlay

Replaces ORIGINAL

260-N, INDEX: 990129

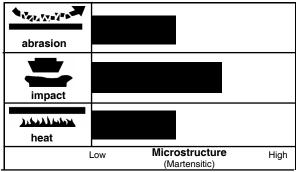
DESCRIPTION:

VertiWear 600 deposits a multi-purpose martensitic steel alloy. It has excellent operator appeal in all positions and can be used to surface mild and low alloy steel components subject to moderate abrasive wear and medium to high impact. Deposits can be applied crack-free in multiple layers with proper procedures.

OPERATIONAL CHARACTERISTICS:

VertiWear 600 is a gas-shielded, flux-cored, all-purpose wire designed to operate in a smooth, semi-spray arc transfer with 100% CO₂ or 75% Ar/25% CO₂ shielding gas. The operation is superior to competitive gas-shielded hard surfacing wires, allowing higher deposition and greater productivity in out-of-position applications.

RELATIVE WEAR RESISTANCE:



TYPICAL WELD METAL PROPERTIES* (CHEM PAD): Weld Metal Analysis

Carbon (C)	0.40	
Manganese (Mn)	0.75	
Silicon (Si)	0.60	
Chromium (Cr)	6.50	
Molybdenum (Mo)	1.00	
Iron (Fe)	Bal.	

TYPICAL MECHANICAL PROPERTIES* (AS WELDED):

	Number of Layers	As-Dep 1020	osited on Steel
Hardness	1	52 Rc	
	2	56	Rc
	3 - 8	57	Rc
Hardness As-Deposited	Time at Temp.	Hardness after Tempering 1000°F 1150°F	
55	10 Hrs.	54	46
	20 Hrs.	49	40
	80 Hrs.	47	40

continued on back

^{*}The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and McKay expressly disclaims any liability incurred from any reliance thereon. No data is to be construed as a recommendation for any welding condition or technique not controlled by McKay.



(contined)

Abrasion resistance	Good	
Impact resistance	Good	
Machinability	Good	
Flame cutting	Difficult	
Magnetic		

RECOMMENDED OPERATING PARAMETERS:

Diame Inches	eter mm	Position	Stick Inches	k-Out mm	Optimum Amps	Volts	Wire Fo	eed Speed mpm
0.45	1.2	Flat Horizontal Vertical	1/2 1/2 1/2	13.0 13.0 13.0	185 180 165	28 24 24	265 255 225	6.7 6.5 5.7
1/16	1.6	Flat Horizontal	3/4 3/4	19.2 19.2	280 265	29 25	280 265	8.1 7.5
		Horizontai Vertical	3/4 3/4	19.2 19.2	265 250	25 25	265 250	7.5 7.0

Parameters may be adjusted ± 25 amps and ± 1 volt for optimum performance. A constant potential power source is recommended, using DCEP polarity with 75% Ar/25% CO₂ or 100% CO₂ shielding gas.

AVAILABLE DIAMETERS AND PACKAGES:

Diameter Inches mm		25 lb. Spool
.045	1.2	S607112-029
1/16	1.6	S607119-029

APPLICATIONS:

- · Coupling Boxes
- · Dragline Chain
- Dredge Ladder Rolls
- Kiln Trunnions
- Mill Guides
- · Sliding Metal Parts
- · Wobber Ends