



PRODUCT DATA SHEET

WCD 6808

HARDFACING GAS SHIELDED FLUX CORED WIRES

Vertiwear-600



SUMMARY

- > Suites Out of Position Applications
- > Multi-Purpose Martensitic Steel
- > Moderate Abrasive Wear and Medium to High Impact
- > Weld Deposits - Machineable

CLASSIFICATION

- > AS/NZS 2576: 1855-B5*
- *Nearest Classification

DESCRIPTION

McKAY Vertiwear 600 is a gas shielded, all position, hard surfacing flux cored wire designed to operate in a smooth semi-spray arc transfer. The weld metal control is superior to competitive gas shielded hard surfacing wires allowing higher deposition and greater productivity in out of position applications. Excellent operator appeal in all positions.

McKAY Vertiwear 600 deposits a multi-purpose martensitic steel alloy and can be used to hard surface mild and low alloy steel components subject to moderate abrasion coupled with medium to high impact. It also exhibits excellent compressive strength and metal-to-metal wear resistance.

The recommended shielding gas for Vertiwear 600 is 75% Argon - 25% CO₂.

OPERATIONAL DATA

The recommended operating parameters are for DC positive with an electrode stick out length of 20 - 35mm.

WIRE SIZE (MM)	WELDING CURRENT RANGE (A)	ARC VOLTAGE RANGE *(V)
1.2	165 - 185	24 - 28

Welding Current DC +

*Voltage is determined by arc current and wire arc length.

Welding currents and voltage shown are operational guides only.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	Cr	Mo	Fe
0.40	0.75	0.60	6.50	1.00	Bal

TYPICAL MECHANICAL PROPERTIES (AS WELDED)

	NUMBER OF LAYERS	AS-DEPOSITED ON 1020 STEEL	
		1020 STEEL	
Hardness	1	52 HRc	
	2	56 HRc	
	3 - 8	57 HRc	
HARDNESS AS-DEPOSITED	TIME AT TEMP	HARDNESS AFTER TEMPERING	
		535°C	620°C
55	10 Hours	54 HRc	46 HRc
	20 Hours	49 HRc	40 HRc
	80 Hours	47 HRc	40 HRc
Abrasion Resistance		Good	
Impact Resistance		Good	
Non-Machinable		Good	
Flame Cutting		Difficult	
Magnetic			

APPLICATIONS

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

PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE AND TYPE	PART NO.
1.2	15kg Spool	S607112-029-015

The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Welding Industries of Australia expressly disclaims any liability incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with the AWS and or AS/NZS specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique by Welding Industries of Australia.

Issue CA - December 2014



welding.com.au 1300 300 884