

### TUBE-ALLOY 240-0



#### SUMMARY

- > Self Shielded or Open Arc Hard Surfacing Flux Cored Wire
- > General Purpose Alloy with Good Abrasion and Impact Resistance
- > Chromium Carbide - Alloy Steel  
Non Machinable, Difficult to Grind

#### CLASSIFICATION

- > AS/NZS 2576: 2155-B7

#### DESCRIPTION

McKAY Tube-Alloy 240-0 is a self shielded, flux cored hard surfacing wire that deposits a chromium carbide alloy steel. It is an "excellent general purpose alloy due to a combination of good abrasion and impact resistance.

McKAY Tube-Alloy 240-0 is designed for overlaying carbon, low alloy or austenitic manganese base metals. The smooth globular type arc transfer gives minimal spatter and the minimum slag cover allows the wire to operate well without de-slugging between weld passes in automatic applications.

Some relief check cracking will occur however it is not detrimental to the wear properties of the deposit and provides some degree of stress relief for the weld metal.

#### OPERATIONAL DATA

The recommended operating parameters are for DC positive with an electrode stick out of 16-25mm for the 1.2mm size, 25-35mm for 1.6mm. Out-of-position welding is limited to a horizontal shelf technique.

WIRE SIZE (MM)	WELDING CURRENT RANGE (A)	ARC VOLTAGE RANGE *(V)
1.2	120 - 275	19 - 27
1.6	275 - 400	24 - 29

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	P	S
3.20	1.80	1.90	15.50	Bal

#### TYPICAL MECHANICAL PROPERTIES (AS WELDED):

	NUMBER OF LAYERS	AS-DEPOSITED ON	
		1020 STEEL	Mn STEEL
Hardness	1	40 Rc	35 Rc
	2	48 Rc	42 Rc
	3 - 5	52 Rc	52 Rc
Abrasion Resistance:		Very Good	
Impact Resistance:		Fair	
Non-Machinable:		Grinding is difficult	
Cannot be Flame Cut			
Deposit will Relief Check Cracks			
Thickness should be Limited to Five Layers Maximum			

#### APPLICATIONS

- > Ammonia Knives
- > Augers
- > Bucket Teeth and Lips
- > Bulldozer End Bits & Blades
- > Conveyer Screws
- > Crusher Jaws and Cones
- > Crusher Rolls
- > Cultivator Chisels & Sweeps
- > Dragline Buckets
- > Sheepsfoot Tampers
- > Dredge Pump Impellers and Side Plates
- > Hammer Mill Hammers
- > Impactor Crusher Bars
- > Manganese Pump Shells
- > Mill Guides
- > Muller Tires
- > Pipeline Ball Joints
- > Pulverizer Hammers
- > Scraper Blades
- > Screw Conveyors
- > Sizing Screens

#### PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE AND TYPE	PART NO.
1.2	11.3kg spool	S604012-029
1.6	11.3kg spool	S604019-029

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