PRODUCT DATA SHEET

WCD 6800

HARDFACING SELF SHIELDED FLUX CORED WIRES

TUBE-ALLOY 258-0

SUMMARY

> Self Shielded or Open Arc Hard Surfacing Flux Cored Wire
> Hard Wearing Martensitic Steel Alloy Deposit
> Tough, Hard Tool Steel Weld Metal Composition
> Good Impact and Abrasion Resistance
> Excellent Resistance to Metal-to-Metal Wear
> Weld Deposits Grindable Only

CLASSIFICATION

> AS/NZS 2576: 1550-B7*
*Nearest Classification

DESCRIPTION

McKAY Tubealloy 258-O is a fabricated type, open arc tubular flux cored wire depositing a Cr-Mo-W Martensitic steel alloy. It is designed for surfacing mild and low alloy steel components subject to moderate abrasive wear and impact under high compressive stresses and/or at temperatures up to 530°C.

Crack free deposits can be obtained by controlled heat input or the use of preheat.

OPERATIONAL DATA

Welding parameters shown below are for DC electrode positive. An electrode stick out length of 12-25mm is recommended for 1.2mm size, 25-35mm for 1.6mm.

WIRE SIZE (MM)	WELDING CURRENT RANGE (A)	ARC VOLTAGE RANGE *(V)
1.2	120 - 275	24 - 27
1.6	275 - 400	30 - 34

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	W	Fe
0.45	1.40	0.80	6.00	1.50	1.50	Bal

TYPICAL MECHANICAL PROPERTIES (AS WELDED):

	NUMBER OF LAYERS	AS-DEPOSITED ON	
		1020 STEEL	Mn STEEL
Hardness	1	49 Rc	51 Rc
	2	53 Rc	54 Rc
	3 - 5	57 Rc	57 Rc
Abrasion Resistance:		Good	
Impact Resistance:		Good	
Non-Machinable:		Grinding only	
Flame Cutting:		Difficult	
Thickness should be Limited to Five Layers Maximum			

APPLICATIONS

> Coupling Boxes
> Dragline Chains
> Kiln Trunnions
> Mill Guides
> Spindles
> Wobbler Ends

PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE (KG)	PART NO.
1.2	11.3	S605812-029
1.6	11.3	S605819-029

Issue CA - 1st February 2013