

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 fluxcored 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	1.0	Bal

TYPICAL MECHANICAL PROPERTIES (AS WELDED):

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

APPLICATIONS

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

PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE (KG)	PART NO.
1.2	11.3	S607112-029

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 - 1st February 2013