PRODUCT DATA SHEET

Tube Alloy 255-G

Tube Alloy 255-G is a metal cored, gas shielded wire depositing a premium chrome carbide alloy that is extremely resistant to abrasion. It will outlast competitive martensitic wires by 9 to 1.

Applications

Tube Alloy 255-G is suitable for use on ammonia knives, augers, bucket teeth and lips, bulldozer end bits and blades, cement chutes, coal feeder screws, coal pulveriser hammers and tables, coke chutes, coke pusher shoes, conveyor screws, crusher jaws and cones, crusher rolls, cultivator chisels and sweeps, dragline buckets, dredger cutter heads and teeth, dredge pump inlet nozzle and side plates, grizzly bars and fingers, manganese pump shells, muller tyres, ore and coal chutes, pipeline ball joints, pug mill paddles, ripper shanks, road rippers, scraper blades, screw conveyors, sheep's foot tampers, sizing screens and sub soiler teeth.

Classifications		
DIN	8555	MF10-GF-60-G

Typical Chemical Analysis (All weld metal)			
% Carbon	5,3	**% Silicon**	0,4
% Manganese	1,0	**% Chromium**	18,0

Typical Mechanical Properties	
Abrasion Resistance	Excellent
Impact Resistance	Poor
Machinability	Grinding is difficult
Flame Cutting	Cannot be flame cut
Thickness	3 layers max
Microstructure	Massive chrome carbide in an austenite-carbide matrix
Deposit will relief check crack	
Maintains hot hardness to 675°C	

Typical Hardness		
Layer	**1020 Steel**	**Mn Steel**
1	58 HRc	47 HRc
2	61 HRc	51 HRc
3	65 HRc	54 HRc

Welding Data (DC+)				
Diameter (mm)	**Current**		**Electrode Stick Out**	**Deposition Rate (kg/hr)**
	Amps (A)	**Volts (V)**		
1,2	150 - 180	22 - 24	13 - 25	3,2

Packing Data			
Diameter (mm)	**Spool Mass (kg)**	**Spool Type**	**Item Number**
1,2	11,3	Spool	W077073

Recommended shielding gas: Fluxshield®, Stainshield® (MIG)

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