

**Tube Alloy 258Tic-O**

Tube Alloy 258Tic-O is a self-shielded wire depositing a martensitic alloy with finely dispersed titanium carbides (Tic's). It is particularly good for resisting high stress abrasive wear. The

alloy has good hot hardness and deposits can be applied crack free with proper procedures.

**APPLICATIONS**

Tube Alloy 258Tic-O is suitable for use on paving agitator screws, mining machinery, buckets, dipper teeth, pulveriser rings and coal crushers.

**SPECIFICATION**

DIN 8555 MF10-GF-60-G (nearest)

**TYPICAL WELD METAL DATA**

%C	%Mn	%Si	%Cr	%Mo	Ti
2.1	1.3	1.8	7.0	1.6	6.0

Abrasion resistance                      Excellent  
 Impact resistance                      Good  
 Machinability                              Grind only  
 Flame cutting                              Cannot be flame cut  
 Magnetic  
 Microstructure                            Martensitic  
 Maintains hot hardness up to 500°C

**TYPICAL HARDNESS RANGE HRc**

Layer	1020 Steel
1	60
2	55
3	48

**RECOMMENDED WELDING DATA**

Tube Alloy 258Tic-O can be used on DCEP

Dia mm	Current	Volts	Electrode Stickout	Deposition Rate Kg/hr
1.6	275-350	24-27	25-38	4.5
2.8	400-450	26-29	38-51	6.4

**PACKAGING DATA**

Dia mm	Item Number	Spool Mass Kg	Spool Type
1.6	077136	11.34	Spool
2.8	077138	27.2	Coil

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