

PRODUCT DATA SHEET

Tube Alloy Build Up-O

Tube Alloy Build Up-O is a self-shielded wire depositing a low alloy steel. It is designed for build-up on carbon and low alloy steels only. The weld metal has good compressive strength, impact and crack resistance, making it excellent as a base for more abrasion resistant overlays.

Applications

Tube Alloy Build Up-O is suitable for use on bucket teeth and lips, crane wheels, dragline buckets and dragline chains, dredger ladder rolls, gear teeth, kiln trunnions, mine car wheels, spindles, steel shafts and wobbler ends.

Classifications

DIN	8555	MFI-GF-300-P
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Typical Chemical Analysis (All weld metal)

% Carbon	0,12	% Silicon	0,8
% Manganese	2,8	% Chromium	1,2

Typical Mechanical Properties

Abrasion Resistance	Fair
Impact Resistance	Very good
Machinability	Excellent
Flame Cutting	Can be flame cut
Microstructure	Low carbon martensitic
Magnetic	

Typical Hardness

Layer	1020 Steel	4130 Steel
1	34 HRc	41 HRc
2	30 HRc	32 HRc
3	30 HRc	29 HRc

Welding Data

(DC+)

Diameter (mm)	Current		Electrode Stick Out	Deposition Rate (kg/hr)
	Amps (A)	Volts (V)		
1,2	160 - 190	24 - 25	13 - 25	3,2
1,6	275 - 350	24 - 27	25 - 38	4,5
2,8	400 - 450	26 - 29	38 - 51	6,4

Packing Data

Diameter (mm)	Spool Mass (kg)	Spool Type	Item Number
1,2	11,3	Spool	W077092
1,6	11,3	Spool	W077096
2,8	27,2	Coil	W077098

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