



PRODUCT DATA SHEET

HARDFACING SOLID MIG WIRES

WCD 6438

Austmig TD-600



SUMMARY

- > Copper Coated, Chromium Alloy Gas Metal Arc (MIG) Welding Wire
- > For Hard Surfacing Components Subjected to Severe Abrasion and Heavy Impact

CLASSIFICATION

- > AS/NZS 2576: 1855-B6

DESCRIPTION

Austmig TD - 600 is a copper coated, chromium alloy welding wire depositing weld metal with a hardness of 55 - 60 HRc which has a high resistance against severe abrasion and impact.

The deposit is non-machineable but can be shaped by grinding.

Typical applications include: excavator blades, bucket lips, bucket teeth, screw conveyors, crushing mills and shear blades.

OPERATIONAL DATA

| ELECTRODE SIZE (MM) | WELDING CURRENT RANGE *(A) | ARC VOLTAGE RANGE *(V) |
|---------------------|----------------------------|------------------------|
| 1.2 | 120 - 340 | 18 - 32 |

Welding Current DC +

*Voltage is determined by arc current and electrode arc length.

Welding currents and voltage shown are operational guides only.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

| C | Si | Mn | P | S | Cr | Fe |
|------|-----|------|-------|-------|-----|-----|
| 0.45 | 3.0 | 0.40 | 0.018 | 0.002 | 9.3 | Bal |

Recommended Shielding Gases:

Argon/18 - 25% CO₂, Ar/CO₂ or 100% CO₂

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

As Welded - Two Layers 55 - 60 HRc

APPLICATIONS

- > Excavator Blades
- > Bucket Teeth
- > Screw Conveyors
- > Crushing Mills
- > Shear Blades

PACKAGING DATA

| ELECTRODE SIZE (MM) | PACK SIZE AND TYPE | PART NO. |
|---------------------|--------------------|-----------|
| 1.2 | 15kg Spool | MTD60012S |

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