



PRODUCT DATA SHEET

WCD 6806

HARDFACING SELF SHIELDED FLUX CORED WIRES

Tube-Alloy A43-0



SUMMARY

- > Self Shielded or Open Arc Hard Surfacing Flux Cored Wire
- > Niobium-Chromium Carbide Iron Weld Deposit
- > Resistant to Severe High and Low Stress Abrasion
- > Low to Moderate Impact Loading
- > Weld Deposits are to be Shaped by Grinding Only

CLASSIFICATION

- > AS/NZS 2576: 2460-B7

DESCRIPTION

McKAY Tube-Alloy A43-0 is a fabricated type, self shielding tubular flux cored wire depositing a high chromium-niobium surfacing alloy which resists severe high and low stress abrasion and low to moderate impact.

The weld deposit will check crack readily and out performs straight C-Cr hard surfacing alloys. It can also be used where high temperature (650°C) wear resistance is required. Spatter level is low, slag cover is minimal and is easily removed.

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)
1.6	225 - 350	23 - 29

Welding Current DC +

Other wire sizes and spool weights are available on indent only.

*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	Cb	Fe
5.50	0.20	1.00	22.00	6.50	Bal

TYPICAL MECHANICAL PROPERTIES (AS WELDED)

	NUMBER OF LAYERS	AS-DEPOSITED ON	
		1020 STEEL	Mn STEEL
Hardness	1	56 - 60 HRc	45 - 50 HRc
	2	60 - 64 HRc	54 - 58 HRc
Abrasion Resistance		Excellent	
Impact Resistance		Poor	
Non-Machinable		Grinding Only	
Can Not Be Flame Cut			
Deposit Will Relief Check Crack			
Thickness 2-3 Layers Maximum			

APPLICATIONS

- > Augers
- > Coal Feeder Screws
- > Coke Chutes
- > Conveyer Screws
- > Grizzly Bars and Fingers
- > Muller Tires
- > Pipeline Ball Joints
- > Scraper Blades
- > Sizing Screws
- > Dredge Cutter Heads and Teeth
- > Dredge Pump Inlet Nozzle and Side Plates
- > Bucket Lips and Teeth
- > Coal Pulverizer Rolls and Tables
- > Coke Pusher Shoes
- > Fan Blades
- > Pipeline Ball Joints
- > Paving Agitator Screws
- > Pub Mill Paddles
- > Sheepsfoot Tampers

PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE AND TYPE	PART NO.
1.6	11.3kg Spool	S607719-029

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