



# PRODUCT DATA SHEET

# WCD 6438

## GAS SHIELDED HARD SURFACING MIG WIRE

### AUSTMIG TD-600



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

#### Classifications

AS/NZS 2576            1855-B6  
 WIA TECH NOTE 4    1855-B6

#### Description & Applications

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, shear blades.

#### Operational Data

WIRE SIZE (mm)	WELDING CURRENT RANGE (amps)	ARC VOLTAGE RANGE (volts)*
1.2	120 - 340	18 - 32

DC+ Electrode Positive

\* 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	Si	Mn	P	S	Cr
0.45	3.00	0.40	0.025	0.020	9.00

#### Typical All Weld Metal Mechanical Properties

AS WELDED - TWO LAYERS	55 - 60 HRc
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Recommended Shielding Gases:  
 Argon/18 - 25% CO<sub>2</sub>, Ar/CO<sub>2</sub> or 100% CO<sub>2</sub>

#### Packaging Data

PACK SIZE	PART NUMBER
15kg	MTD60012S

#### Storage Information

Products should be stored in dry conditions in original sealed undamaged packaging as supplied. The integrity of consumable products can be adversely affected by time and storage conditions and that the detail shown in the batch certificate is true at the time of packaging and is only valid for a LIMITED time. After that time the product may need to be reconditioned or checked to ensure it is suitable for the purpose it is intended to be used for.\*

\*NOTE: Refer to Welding Technology Institute of Australia (WTIA), technical 3. care and conditioning of arc welding consumables.