



# PRODUCT DATA SHEET

# WCD 6800

## SELF SHIELDED HARD SURFACING MIG WIRE

### McKAY TUBEALLOY 258-O



- ▶ Self Shielded or Open Arc Hard Surfacing Flux Cored Wire
- ▶ Hard Wearing Martensitic Steel Alloy Deposit
- ▶ Tough, Hard Tool Steel Weld Metal Composition
- ▶ Good Impact and Abrasion Resistance
- ▶ Excellent Resistance to Metal-to-Metal Wear

#### Classifications

AS/NZS 2576	1550-B7*
WIA TECH NOTE 4	1550-B7*

\*nearest classification

#### Description & Applications

TUBEALLOY 258-O is a fabricated type, open arc tubular flux cored wire depositing a Cr-Mo-W Martensitic steel alloy. It is designed for surfacing mild and low alloy steel components subject to moderate abrasive wear and impact under high compressive stresses and/or at temperatures up to 530°C.

Crack free deposits can be obtained by controlled heat input or the use of preheat.

Typical applications for the TUBEALLOY 258-O are the surfacing of machine components, tools, sliding metal parts, drag line chains, spindles, kiln trunnions, mill guides and applications subject to low stress abrasion. Weld deposits are non-machinable, but can be shaped by grinding only

#### Operational Data

Welding parameters shown below are for DC Electrode positive. An electrode stick out length of 12 - 25mm is recommended for 1.2mm size, 25 - 35mm for 1.6mm.

WIRE SIZE (mm)	WELDING CURRENT RANGE (amps)	ARC VOLTAGE RANGE (volts)*
1.2	120 - 230	24 - 27
1.6	225 - 350	30 - 34

Welding Current DC+

\*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	Mo	W	Fe
0.39	1.43	0.68	6.04	1.32	1.59	Bal

#### Typical All Weld Metal Mechanical Properties

SINGLE LAYER - AS WELDED (on 1045 steel)	TYPICALLY, 50 HRC
THREE LAYER - AS WELDED (on 1045 steel)	TYPICALLY, 57 HRC

#### Packaging Data

WIRE SIZE (mm)	PACK SIZE (kg)	PART NUMBER
1.2	11.3	S605812-029
1.6	11.3	S605819-029

#### 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.

#### Issue AA

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