



# PRODUCT DATA SHEET

# WCD 6806

## SELF SHIELDED HARD SURFACING MIG WIRE

### McKAY TUBEALLOY A43-O



- ▶ 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

#### Classifications

AS/NZS 2576	2460-B7
WIA TECH NOTE 4	2460-B7

#### Description & Applications

TUBE-ALLOY A43-O 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.

Typical applications for the TUBEALLOY A43-O are the surfacing of conveyor screws, wear plates, bucket teeth on bucket wheel excavators, shovel bucket teeth and lips, brick and cement presses, fan blades, grizzly bars and fingers, coke chutes, coal feeder screws, augers.

#### 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 (amps)	ARC VOLTAGE RANGE (volts)*
1.6*	300 - 350	30 - 34

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	Ni	Fe
5.50	0.20	1.0	20.0	6.00	Bal

#### Typical All Weld Metal Mechanical Properties

Deposited weld metal cannot be flame cut and can only be shaped by grinding only. Thickness of the weld overlay should be limited to a maximum of 3 layers.

SINGLE LAYER - AS WELDED (1020 STEEL)	TYPICALLY, 56 - 60 HRC
THREE LAYER - AS WELDED (1020 STEEL)	TYPICALLY, 60 - 64 HRC
SINGLE LAYER - AS WELDED (12-14% Mn STEEL)	TYPICALLY, 46 - 50 HRC
THREE LAYER - AS WELDED (12-14% Mn STEEL)	TYPICALLY, 54 - 58 HRC

#### Packaging Data

PACK SIZE	PART NUMBER
11.3kg	S607719-029

#### 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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