



PRODUCT DATA SHEET

WCD 6808

GAS SHIELDED HARD SURFACING MIG WIRE

McKAY VERTIWEAR-600



- ▶ Suites Out-of Position Applications
- ▶ Multi-Purpose Martensitic Steel
- ▶ Moderate Abrasive Wear and Medium to High Impact

Classifications

AS 2576	1855-B5*
WIA TECH NOTE 4	1855-B5*

*Nearest Classification

Description & Applications

VERTIWEAR 600 is a gas shielded, all position, hard surfacing fluxcored wire designed to operate in a smooth semi-spray arc transfer. The weld metal control is superior to competitive gas shielded hard surfacing wires allowing higher deposition and greater productivity in out-of-position applications. Excellent operator appeal in all positions.

VERTIWEAR 600 deposits a multi-purpose martensitic steel alloy and can be used to hard surface mild and low alloy steel components subject to moderate abrasion coupled with medium to high impact. It also exhibits excellent compressive strength and metal-to-metal wear resistance. Applications include ripper teeth, dozer blades, re facing of agricultural points and equipment, dragline chains and sliding metal parts. The recommended shielding gas for VERTIWEAR 600 is 75% Argon - 25 % CO₂

Operational Data

WIRE SIZE (mm)	WELDING CURRENT RANGE (amps)	ARC VOLTAGE RANGE (volts)*
1.2	165 - 185	24 - 28

Welding Current DC+

Parameters may be adjusted + 25 amps and + 1 volt for optimum performance

* 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	Fe
0.40	0.85	0.70	6.0	0.50	Bal

Typical All Weld Metal Mechanical Properties

If weld metal cracking is experienced in multi-layer deposits a preheat and interpass temperature of 150 - 250°C may be required to prevent cracking.

SINGLE LAYER - AS WELDED (1020 steel)	TYPICALLY, 52 HRC
THREE LAYER - AS WELDED (1020 steel)	TYPICALLY, 57HRC

Packaging Data

PACK SIZE	PART NUMBER
15kg	S607112-029

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 A

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