





# Tube-Alloy® A420M-S

## TYPICAL MECHANICAL PROPERTIES\* (AS WELDED):

Continued

Abrasion resistance	Very good
Impact resistance	Fair
Machinability	Fair with carbide tools
Cannot be flame cut	
Slightly magnetic	
Deposit thickness	As required.

## RECOMMENDED OPERATING PARAMETERS:

Diameter Inches mm	Type of Power	Stick-Out		Travel Speed (per minute)		Optimum Amps	Volts	Deposition Rate lb/hr <sup>†</sup>
		Inches	mm	Inches	mm			
3/32 2.4	DCEP	1 - 1 1/4	25-32	12-16	305-406	350-500	25-29	14-22
1/8 3.2	DCEP	1 1/4 - 1 1/2	32-38	14-18	356-456	400-450	26-28	16
						450-500	27-30	20
						500-550	29-32	24
5/32 4.0	DCEP	1 1/4 - 1 1/2	32-38	16-20	406-508	450-508	450-500	18
							500-600	23

<sup>†</sup>Typical at optimum settings

## AVAILABLE DIAMETERS AND PACKAGES:

Diameter Inches mm	500 lb. Auto-Pak
3.32 2.4	S615629-466
1/8 3.2	S615643-266
5/32 4.0	S615650-466

## APPLICATIONS:

- Back-up Rolls
- Continuous Caster Rolls
- Plate Leveler Rolls
- Straightener Rolls

Material Safety Data Sheets on any McKay product can be obtained from McKay Customer Service. Because McKay is constantly improving product, McKay reserves the right to change design and/or specifications without notice.

Tube-Alloy is a registered trademark of Hobart Brothers Company, Troy, Ohio.