



VertiWear[®] AP

GAS-SHIELDED HARD SURFACING WIRE **Build-UP**

Replaces PRELIMINARY

260-C INDEX: 990129

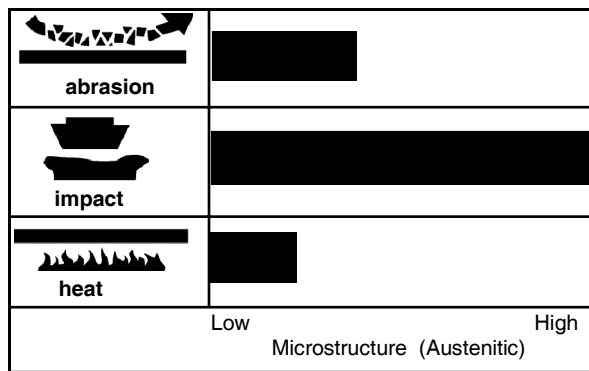
DESCRIPTION:

VertiWear AP is a premium, work-hardening austenitic manganese steel alloy. It can be used for build-up or overlay on austenitic manganese steel. It can also be used for joining austenitic manganese steel to manganese steel, carbon steel, and low-alloy steel. The deposit has an excellent impact resistance and rapidly work-hardens to 50-55 Rc.

OPERATIONAL CHARACTERISTICS:

VertiWear AP is a unique gas-shielded, flux-cored, all-position wire designed to operate in a smooth, semi-spray arc transfer. The deposit has excellent slag removal and appearance. Can be used with either 100% CO₂ or 75% AR/25% CO₂ shielding gas.

RELATIVE WEAR RESISTANCE:



TYPICAL WELD METAL PROPERTIES* (CHEM PAD):

Weld Metal Analysis

Carbon (C)	0.45
Manganese (Mn)	14.00
Silicon (Si)	0.50
Chromium (Cr)	13.50
Nickel (Ni)	0.50
Iron (Fe)	Bal.

TYPICAL MECHANICAL PROPERTIES* (AS WELDED):

	Number of Layers	As Deposited on 1020 Steel
Hardness	1	24 Rc
	2	20 Rc
	3 - 8	18 Rc
Rapidly work hardens to 50-55 Rc		
Abrasion resistance	Good	
Impact resistance	Excellent	
Machinability	Fair	
Cannot be flame cut		

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and McKay expressly disclaims any liability incurred from any reliance thereon. No data is to be construed as a recommendation for any welding condition or technique not controlled by McKay.



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RECOMMENDED OPERATING PARAMETERS:

Diameter		Position	Stick-out		Optimum Amps	Volts	Wire Feed Speed	
Inches	mm		Inches	mm			lpm	mpm
.045	12	Flat	1/2	13	225	26	520	13.2
		Horizontal	1/2	13	180	25	340	8.6
		Vertical	1/2	13	165	25	300	7.6

Parameters may be adjusted ± 25 amps and ± 1 volt for optimum performance. A constant potential power source is recommended, using DC Reverse (+) polarity with 75% Ar/25% CO₂ or 100% CO₂ shielding gas.

AVAILABLE DIAMETERS AND PACKAGES:

Diameter		25-lb. Spool
Inches	mm	
.045	1.2	S606812-029

APPLICATIONS:

- Bucket Teeth and Lips
- Crusher Jaws and Cones
- Dragline Buckets
- Dredge Cutter Heads and Teeth
- Grizzly Bars and Fingers
- Gyratory Crusher Mantles and Cones
- Hammer Mill Hammers
- Hydroelectric Turbines
- Impactor Crusher Bars
- Muller Tires
- Pulverizer Hammers
- Sizing Screens