

VertiWear[®] 600



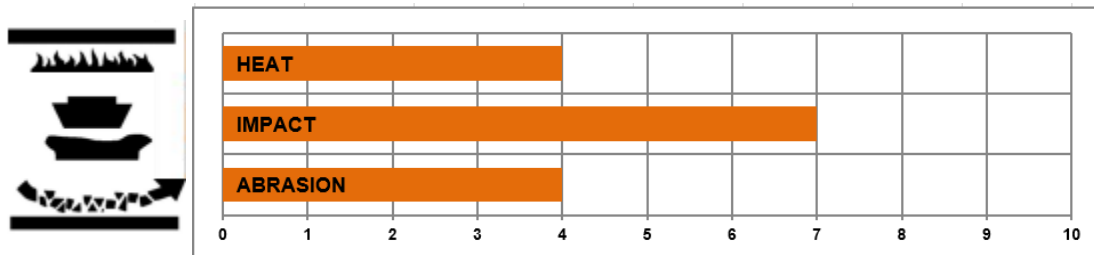
DESCRIPTION:

VertiWear 600 deposits a multi-purpose martensitic steel alloy. It has excellent operator appeal in all positions and can be used to surface mild and low alloy steel components subject to moderate abrasive wear and medium to high impact. Deposits can be applied crack-free in multiple layers with proper procedures.

OPERATIONAL CHARACTERISTICS:

VertiWear 600 is a gas-shielded, flux-cored, all-purpose wire designed to operate in a smooth, semi-spray arc transfer with 75% Ar/25% CO₂ shielding gas (recommended) or 100% CO₂. The operation is superior to competitive gas-shielded hard surfacing wires, allowing higher deposition and greater productivity in out-of-position applications.

RELATIVE WEAR RESISTANCE:



Microstructure: Martensitic
Abrasion resistance: Good
Impact resistance: Good
Machinability: Good
Flame Cutting: Difficult

TYPICAL WELD METAL CHEMICAL COMPOSITION* (Chem Pad):

Weld Metal Analysis	(%)
Carbon (C)	0.40
Manganese (Mn)	0.75
Silicon (Si)	0.60
Chromium (Cr)	6.50
Molybdenum (Mo)	1.00
Iron (Fe)	Balance

TYPICAL DEPOSIT HARDNESS* (AS DEPOSITED):

Layer(s)	1020 Steel
1	52 Rc
2	56 Rc
3-8	57 Rc

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers Company 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 Hobart Brothers LLC.

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TYPICAL DEPOSIT HARDNESS* (TEMPERED):

Time @ Temperature	Temper Temperatures	
	1000°F (538°C)	1150°F (621°C)
10 Hrs.	54 Rc	46 Rc
20 Hrs.	49 Rc	40 Rc
80 Hrs.	47 Rc	40 Rc

RECOMMENDED OPERATING PARAMETERS*:

Diameter Inches (mm)	Type of Power	Position	Optimum Amps	Volts	Wire Feed Speed		CTWD	
					in/min	m/min	Inches	(mm)
0.045" (1.2 mm)	DCEP	Flat	185	28	265	(6.7)	1/2	(12.7)
		Horizontal	180	24	255	(6.5)	1/2	(12.7)
		Vertical	165	24	225	(5.7)	1/2	(12.7)
1/16" (1.6 mm)	DCEP	Flat	295	28.5	255	(6.5)	3/4	(12.7)
		Horizontal	270	24	200	(5.1)	3/4	(12.7)
		Vertical	220	23.5	125	(3.2)	5/8	(15.9)

- Parameters may be adjusted ± 25 amps and ± 1 volt for optimum performance. A constant potential power source is recommended, using DCEP polarity with 75% Ar/25% CO₂
- 100% CO₂ may be used but is not recommended for out of position welds. Recommended minimum of +1 volt when using CO₂

AVAILABLE DIAMETERS AND PACKAGES: For a complete list of diameters and packaging, please contact Hobart Brothers at (800) 424-1543 or (937) 332-5188

Diameter Inches (mm)	33 lb. Spool
Net Pallet Weight	2376-lb. (1078kg)
0.045 (1.2)	S607112-029
1/16 (1.6)	S607119-029

APPLICATIONS:

- Coupling Boxes
- Dragline Chain
- Dredge Ladder Rolls
- Kiln Trunnions
- Mill Guides
- Sliding Metal Parts
- Wobbler Ends

TECHNICAL QUESTIONS? For technical support of Hobart Filler Metals products, contact the Applications Engineering department by phone toll-free at 1-800-532-2618 or by e-mail at Applications.Engineering@HobartBrothers.com

CAUTION:

Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 St, Miami, FL 33166-6672 (can also be downloaded online at www.aws.org); OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210

Safety Data Sheets on any Hobart Brothers LLC product may be obtained from Hobart Customer Service or at www.hobartbrothers.com.

Because Hobart Brothers Company is constantly improving products, Hobart reserves the right to change design and/or specifications without notice.

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