Tube-Alloy® 877-S

Tube-Alloy® 877-S deposit is a low alloy steel composition. It is a sound, tough, build-up alloy designed for use on steel mill con-cast rolls. Mechanical properties are outstanding.

Typical Applications

- continuous caster rolls

Typical Deposit Analysis %

Carbon	0.10
Manganese	1.00
Silicon	0.60
Chromium	1.00
Molybdenum	0.40
Nickel	1.30
Iron	Balance

HF-N/SWX HF-N Flux

Typical Properties

Abrasion Resistance	Fair
Impact Resistance	Very Good
Machinability	Excellent
Thickness	As required

Hardness, as deposited, Rc

No. of Layers	1020 Steel
1	22
2	23
3-8	24

Can be flame cut
Strongly Magnetic

Diameter and Polarity

1/8”
DCEP

Tube-Alloy® 242-S MOD

Tube-Alloy® 242-S Mod deposit is a low alloy medium hardness martensitic steel. It can be used as a hardfacing overlay where good abrasion resistance and machinability are required.

Typical Applications

- crane wheels
- tractor idlers & rollers

Typical Deposit Analysis %

Carbon	0.14
Manganese	1.90
Silicon	0.80
Chromium	3.00
Molybdenum	0.80
Iron	Balance

HF-N/SWX HF-N Flux

Typical Properties

Abrasion Resistance	Good
Impact Resistance	Good
Machinability	Good

Hardness, as deposited, Rc

No. of Layers	1020 Steel	1045 Steel
1	29	44
2	38	45
3	39	40

Can be flame cut
Strongly magnetic

Diameter and Polarity

1/8”
DCEP

Tube-Alloy® 258-S

Tube-Alloy® 258-S deposit is a premium martensitic steel alloy. It is a hard, tough H-12 tool steel composition. It can be used as an overlay on steel mill rolls where high hardness and abrasion resistance are more important than fire cracking.

Typical Applications

- spindles
- table rolls

Typical Deposit Analysis %

Carbon	0.34
Manganese	1.50
Silicon	0.50
Chromium	6.00
Molybdenum	1.50
Tungsten	1.40
Iron	Balance

HF-N/SWX HF-N Flux

Typical Properties

Microstructure	Martensitic
Abrasion Resistance	Good
Impact Resistance	Good
Machinability	Difficult with carbide tools
Thickness	As required

Hardness, as deposited, Rc

No. of Layers	1020 Steel	1045 Steel
1	46	52
2	48	53
3	53	54

Flame cutting is difficult
Magnetic

Diameter and Polarity

3/32”
1/8”
DCEP