Tube-Alloy®260-G

GAS-SHIELDED HARD SURFACING WIRE **Overlay**

Replaces 990129 260-M, INDEX: 080818

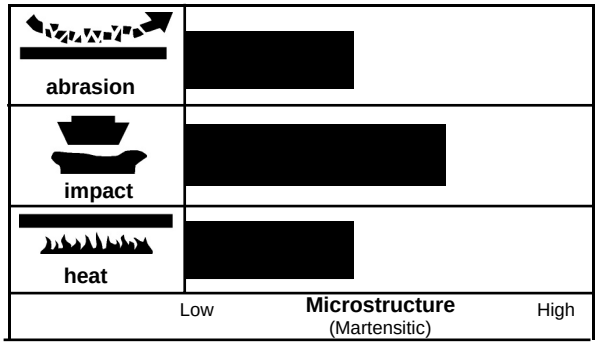
DESCRIPTION:

Tube-Alloy 260-G is a gas-shielded, metal-cored wire that deposits a martensitic alloy steel. It is designed for use as an overlay on carbon and low alloy steels. It has very good resistance to adhesive (metal-to-metal) wear and good resistance to abrasion and impact.

OPERATIONAL CHARACTERISTICS:

Tube-Alloy 260-G can be used with either 100% CO_2 or 75% Ar/25% CO_2 shielding gas. It has excellent operator appeal in allpo sitions and produces a very smooth arc, low fume levels, and virtually slag-free welds.

RELATIVE WEAR RESISTANCE:



TYPICAL WELD METAL PROPERTIES* (CHEM PAD):

Weld Metal Analysis	
Carbon (C)	0.70
Manganese (Mn)	2.00
Silicon (Si)	1.00
Chromium (Cr)	8.00
Iron (Fe)	Bal.

TYPICAL MECHANICAL PROPERTIES* (AS WELDED):

Hardness	55 - 60 Rc
Abrasion resistance	Good
Impact resistance	Good
Machinability	Grinding only
Cannnot be flame cut	
Magnetic	

*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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Tube-Alloy® 260-G

RECOMMENDED OPERATING PARAMETERS:

Diameter Inches	Diameter mm	Type of Power	Stick-Out Inches	Stick-Out mm	Optimum Amps	Volts	Deposition Rate Amps	Deposition Rate lb/hr
0.45	1.2	DCEP	1/2 - 1	13 - 25	120 - 160	19 - 23	130	4
					160 - 190	**24 - 25**	180	7
					190 - 230	26 - 27	220	10
1/16	1.6	DCEP	1 - 1-1/2	25 - 38	225 - 275	23 - 25	200	6
					275 - 350	**24 - 27**	250	10
					350 - 400	26 - 29	300	14

Use with 100% CO_2 or 75%Ar/25% CO_2 shielding gas. Start with **middle ranges** and adjust accordingly. Higher amperages will increase deposition rate, dilution, and heat input to base metal. Increasing voltage will widen and flatten bead profile, but excessive voltage will result in porosity. Too much electrical stick-out may result in increased spatter, too little may result in internal porosity.

AVAILABLE DIAMETERS AND PACKAGES:

Diameter Inches	Diameter mm	25 lb. Spool
.045	1.2	S234212-Z29
1/16	1.6	S234219-Z29

APPLICATIONS:

- Coupling Boxes
- Dragline Chain
- Kiln Trunnions
- Mill Guides
- Sprindles
- Wobbler Ends

Material Safety Data Sheets on any McKay product may be obtained from McKay Customer Service.

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