

Replaces HS-126 (990129)

270-A, INDEX: 120711

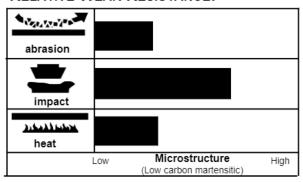
DESCRIPTION:

Tube-Alloy BU-S deposit is low alloy steel composition. It can be used for build-up on mild and low alloy steel components. The weld metal has good compressive strength, making it an excellent base for surfacing.

OPERATIONAL CHARACTERISTICS:

Tube-Alloy BU-S is a high-deposition rate wire that produces sound, porosity-free, crack-free weld deposits. McKay HF-N flux is recommended.

RELATIVE WEAR RESISTANCE:



TYPICAL WELD METAL PROPERTIES* (CHEM PAD): Weld Metal Analysis

Carbon (C)	0.12
Manganese (Mn)	1.80
Silicon (Si)	0.80
Chromium (Cr)	0.70
Iron (Fe)	Bal.

TYPICAL MECHANICAL PROPERTIES* (As WELDED):

	Number of	As Deposited on			
	Layers	1020 Stee	el	1045 Steel	
Hardness	1	20 Rc	:	35 Rc	
	2	26 Ro	:	34 Rc	
	3	30 Rc	:	31 Rc	
Hardness As-Deposited	Time at Temp.	Hardness after Tempering 950°F 1050°F 1		npering 1150°F	
31 Rc	6 Hrs.	24 Rc	21 Rc	20 Rc	
	10 Hrs.	23 Rc	20 Rc	19 Rc	
	20 Hrs.	22 Rc	19 Rc	17 Rc	

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^{*}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.



Tube-Alloy® BU-S

TYPICAL MECHANICAL PROPERTIES* (As WELDED):

(continued)

<u> </u>
Abrasion resistance - fair
Impact resistance - very good
Machinability - excellent
Can be flame cut
Strongly magnetic
Deposit thickness - as required

RECOMMENDED OPERATING PARAMETERS:

Diam Inches		Type of Power	Stick-O	ut mm	Travel (per m Inches	•	Optimum Amps	Volts	Deposition Rate lb/hr¹
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	450-500	28-30	18
							500-600	29-32	23

¹ Typical at optimum settings

AVAILABLE DIAMETERS AND PACKAGES:

Diam Inches		250 lb. Auto-Pak	500 lb. Auto-Pak
1/8	3.2	S613243-065	S613243-266
5/32	4.0	_	S613250-066

APPLICATIONS:

- · Crane Wheels
- · Dredge Ladder Rolls
- · Mine Car Wheels
- Sprindles
- Table Rolls
- · Tractor Idlers and Rollers