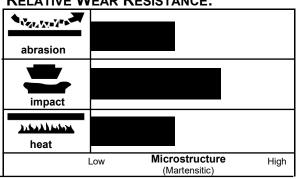


# **DESCRIPTION:**

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 100% CO<sub>2</sub> or 75% Ar/25% CO<sub>2</sub> shielding gas. 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:**

## **TYPICAL WELD METAL PROPERTIES\* (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)	Bal.

## **TYPICAL MECHANICAL PROPERTIES\* (As Welded):**

	Number of Layers		oosited on Steel
Hardness	1	52	2 Rc
	2	56	6 Rc
	3 - 8	57	7 Rc
Hardness As-Deposited	Time at Temp.	Hardness a 1000°F	after Tempering 1150°F
55	10 Hrs.	54	46
	20 Hrs.	49	40
	80 Hrs.	47	40
		C	ontinued on back

\*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 Company.

# VertiWear® 600

#### (continued)

Abrasion resistance	Good	
Impact resistance	Good	
Machinability	Good	
Flame cutting	Difficult	
Magnetic		

### **RECOMMENDED OPERATING PARAMETERS:**

Diameter			Stick-Out		Optimum		Wire Feed Speed	
Inches mm Position	Inches	mm	Amps	Volts	lpm	mpm		
0.45	1.2	Flat	1/2	13.0	185	28	265	6.7
		Horizontal	1/2	13.0	180	24	255	6.5
		Vertical	1/2	13.0	165	24	225	5.7
1/16	1.6	Flat	3/4	19.2	280	29	280	8.1
		Horizontal	3/4	19.2	265	25	265	7.5
		Vertical	3/4	19.2	250	25	250	7.0

Parameters may be adjusted  $\pm 25$  amps and  $\pm 1$  volt for optimum performance. A constant potential power source is recommended, using DCEP polarity with 75% Ar/25% CO<sub>2</sub> or 100% CO<sub>2</sub> shielding gas.

## **AVAILABLE DIAMETERS AND PACKAGES:**

Dia Inches	meter mm	25 lb. Spool
.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 <u>Applications.Engineering@hobartbrothers.com</u>

#### 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 36th St., Miami, FL 33166 (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 Company 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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