

PRODUCT DATA SHEET

Tube Alloy 240-O

Tube Alloy 240-O is a self-shielded flux cored wire depositing a chrome carbide alloy steel. The deposit's combination of very good abrasion resistance and moderate impact resistance makes it an excellent general purpose alloy. Some stress relief cracking will occur and is not detrimental to the wear properties.

screws, crusher jaws and cones, crusher rolls, cultivator chisels and sweeps, dragline buckets, dredge pump impellers and side plates, hammer mill hammers, impact crusher bars, manganese pump shells, mill guides, muller tyres, pipeline ball joints, pulveriser hammers, scraper blades, screw conveyors, sheep's foot tampers and sizing screens.

Applications

Tube Alloy 240-O is suitable for use on ammonia knives, augers, bucket teeth and lips, bulldozer end bits and blades, conveyor

Classifications

DIN	8555	MF10-GF-50-G
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Typical Chemical Analysis (All weld metal)

% Carbon	3,2	% Silicon	1,9
% Manganese	1,8	% Chromium	15,5

Typical Mechanical Properties

Abrasion Resistance	Very good
Impact Resistance	Fair
Machinability	Grinding is difficult
Flame Cutting	Cannot be flame cut
Thickness	5 layers max
Microstructure	Chrome carbide in an austenite-carbide matrix
Deposit will relief check crack	

Typical Hardness

Layer	1020 Steel	Mn Steel
1	40 HRc	35 HRc
2	48 HRc	42 HRc
3	52 HRc	50 HRc

Welding Data

(DC+)

Diameter (mm)	Current		Electrode Stick Out	Deposition Rate (kg/hr)
	Amps (A)	Volts (V)		
1,2	160 - 190	24 - 25	13 - 25	3,2
1,6	275 - 350	24 - 27	23 - 38	4,5

Packing Data

Diameter (mm)	Spool Mass (kg)	Spool Type	Item Number
1,2	11,3	Spool	W077112
1,6	11,3	Spool	W077116

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