

Vecalloy M Advanced Welding Wire

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PRODUCT OVERVIEW

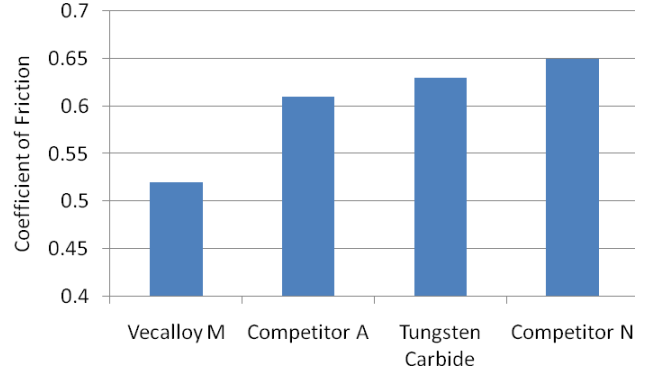
Vecalloy M Advanced Welding Wire is a revolutionary development utilizing proprietary atomic-scale computational methods and models to engineer next generation welding materials. Vecalloy M is available in .045, 1/16, 1/8 inch diameter wires and is designed for commercial wire-fed welding systems. Vecalloy M is iron-base and provides exceptional wear and corrosion resistance.

Vecalloy M is suited for applications in which wear and corrosion combine to create conditions that challenge conventional solutions. Examples of such environments include:

- Severe abrasive environment such as oil sand, mining, and construction.
- Sliding wear surfaces such as materials handling and energy production.
- Salt fog environments such as marine.

Vecalloy M's physical properties offer superior performance: strength, hardness, elasticity, wear and corrosion resistance that drive value to its end users. This provides Vecalloy with a lower cost relative to traditional alloy solutions that Vecalloy displaces.

Theoretical Density:	8 g/cc
Hardness, one pass, mild steel:	50-55 RC
Melting Temperature, °F(°C):	2300 (1275)
Corrosion Resistance:	Excellent
Wear Resistance:	Excellent ASTM G65, ASTM G77
Coefficient of Friction	<0.55 ASTM G 77
Chemical Composition (wt. %):	
C <5%	B <4%
Cr <25%	Ni <8%
Nb <15%	Fe Bal.
Particle CTE:	5.7 x 10 ⁻⁶



Coefficient of Friction Comparison for Vecalloy M

Welding Parameters*

Vecalloy M	Millermatic 250X
Arc Load Volts	29-32
Current, Amps	250 - 300
Recommended Shielding Gas	98/2 Ar/O2 75/25 Ar/CO2
Wire Size, inch	1/16

Parameters available upon request for other MIG systems.

*These parameters are a starting point. Always observe industry standard safety procedures and equipment with approved eye, ear, and respiratory protection in place. Read and understand the MSDS. Do not operate equipment in a manner not approved by manufacturer.