



FUSION™ 600 is a high chromium cast iron for hardsurfacing components subject to extreme abrasive wear and moderate impact. The deposit of FUSION™ 600 contains a high quantity of hard primary chromium carbides in a tough austenitic matrix. The deposit produced is similar to CHROMEWELD™ 600. Using special weld settings, FUSION™ 600 can be welded out of position. This product is used for hardfacing components experiencing wear by sand, earth and abrasives.

Typical Deposit Characteristics

Abrasion Resistance Excellent
Hardness 58 - 65 HRc (61 HRc avg.)
Impact Resistance Moderate
Deposit Layers Up to 3

Operational Characteristics/ Welding Parameters

	0.045" Range	0.045" Horizontal	0.045" Vertical	1/16" Range	1/16" Horizontal	1/16" Vertical
Stickout	1/2" – 1 1/2"	3/4"	5/8"	1/2" – 1 1/2"	3/4"	5/8"
Voltage	19 – 32	25	21	20 – 34	26	21
Wire Speed	110 – 450" / min	290" / min	115" / min	85 – 350" / min	225" / min	90" / min
Amps Produced	100 – 300	200	105	100 – 350	205	110

Current Type CV DCEP
Shielding Gas No shielding gas required

TYPICAL ALL-WELD METAL ANALYSIS			
C 5.7	Mn 0.5	Si 1.6	Cr 31

Alloy Types

Primary carbides and eutectic carbides of the M7C3 type in an austenitic matrix

Typical Applications

- Dredge Pump Bodies
- Earth Moving Equipment
- Mining Equipment
- Sand Dredge Parts
- Sugar Mill Equipment
- Brick Muller Tyres
- Coal Pulverizer Rolls

Standard Sizes & Packaging

Diameter: 0.045" (1.2mm) OR 1/16" (1.6mm)
Packaging: 33 lbs. Spools OR 55 lbs. Coil