

**DESCRIPTION**

SA Super 20 deposit is a very highly alloyed chromium-tungsten-moly-iron used for service involving very severe abrasive conditions and hot wear up to 1100°F. The abrasion resistance of this alloy approaches that of a tungsten carbide and thus has been given the name “the poor man’s tungsten carbide”.

**TYPICAL DEPOSIT CHARACTERISTICS**

Abrasion Resistance	Excellent
Impact Resistance	Low – Moderate
Hardness	
1 Layer on Mild Steel	HRC 60 – 65
1 Layer on Mang Steel	HRC 58 – 63
Surface Cross Checks	Yes
Hot Wear Applications	Up to 1100°F
Machinable	No

**ALLOY TYPE**

Primary Chromium Carbides and secondary Mo and WC Carbides in an austenitic matrix.

**TYPICAL APPLICATIONS**

Typical applications include:

- Shredder Wear Parts
- Feed Mill Hammers
- Coke Pusher Shoes
- Spiral Conveyors
- Sintering Plant Parts
- Ash Fans
- Pulverizers
- Hot Slap Dipper Teeth
- Pug Mill paddles
- Anhydrous Ammonia Plows

**OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS**

Diameter, In. (mm)	<b>1/16 (1.6)</b>	<b>7/64 (2.8)</b>
Current, Amp. DC+	200 – 250	350 – 500
Voltage	24 – 28	26 – 30
Wire Extension	1” – 1 ¼”	1” – 1 ½”
Shielding Gas	None or CO <sub>2</sub>	None
Position	Flat or	Flat Only
	Horizontal	

**STANDARD SIZES & PACKAGING**

Diameter	Packaging	Part #
1/16” (1.6mm)	33# WB	11456000
1/16” (1.6mm)	50# PP	11896900
7/64” (2.8mm)	60# Coil	64750755

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PDS-CRC-W-013

Revision 1  
07/24/02

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