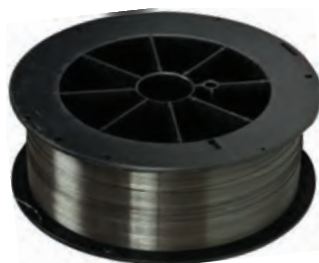


Product Information Report

VX Hardfacing Wire Technical Information



Cronatron™
A LAWSON BRAND



Overview

Incredible hardfacing wires at a competitive price. Combine these products with our exceptional technical knowledge and service and you have the most complete, highest value hardfacing package in the industry.

- Great Products – our hardfacing wires have been thoroughly tested to perform in the harshest wear environments, but at the same time to provide an easy-to-use, great operating product
- Technical Knowledge – your agent will work with you and our Engineering Department to best determine product selection and procedure to maximize your wear life
- Service – we strive to deliver what you want, when you want it, and guarantee you will be happy with the results

Application and Product Selection Chart

	Wood	Coal or Sandstone	Sand	Gravel	Small Rock	Large Rock	Metal
Cheek or Side Plate of Small Buckets	5 – 9	4 – 10	7 – 10	4 – 7	4 – 6	3 – 5	3 – 7
Bottom Plates of Small Buckets	5 – 9	4 – 10	7 – 10	4 – 7	4 – 6	3 – 5	3 – 7
Leading Edges of Small Buckets	3 – 5	3 – 7	7 – 10	3 – 6	3 – 5	2 – 4	3 – 5
Cheek or Side Plate of Large Buckets	4 – 9	4 – 10	7 – 10	4 – 7	4 – 6	3 – 5	4 – 6
Bottom Plates of Large Buckets	4 – 9	4 – 10	7 – 10	4 – 7	4 – 6	3 – 5	4 – 6
Leading Edges of Large Buckets	3 – 6	3 – 6	7 – 10	3 – 6	2 – 5	1 – 4	2 – 5
Dozer and Grader Blades	3 – 6	7 – 10	5 – 10	3 – 7	2 – 4	1 – 4	2 – 4
Cutting Edges of Dozer and Grader Blades	2 – 4	4 – 10	3 – 10	2 – 4	2 – 3	1 – 3	2 – 3
Blade Shoes	4 – 6	4 – 6	7 – 10	5 – 9	5 – 7	4 – 6	4 – 7
Dump Beds	3 – 7	3 – 9	4 – 10	5 – 9	5 – 7	4 – 6	4 – 7
Chutes with Low Drop Heights <2 ft.	4 – 10	4 – 10	7 – 10	4 – 10	3 – 6	1 – 4	3 – 6
Chutes with Moderate Drop Heights < 2 ft. to 6 ft.	4 – 7	4 – 7	7 – 10	4 – 7	2 – 5	1 – 3	2 – 5
Chutes with High Drop Heights > 6 ft.	3 – 5	3 – 7	7 – 10	3 – 7	1 – 4	1 – 2	1 – 4
Cyclones	–	4	4	–	–	–	–
Roll Crushers	2 – 5	2 – 5	–	1 – 5	1 – 4	1	1 – 4
Small Hammers	2 – 4	1 – 4	–	–	–	1 – 2	1 – 4
Large Hammers	1 – 3	1 – 3	–	–	–	1	1 – 3
Shears or Blades	Use 345 or MAD-H H65						
Augers	7 – 10	7 – 10	7 – 10	6 – 10	5 – 10	–	3 – 5

Use this chart to help select the appropriate product. The appropriate product selection will vary on the details of the application. The above number corresponds to the "H" number in the product name. The "H" number refers to the relative abrasion resistance of the product. The higher the "H" number, the higher the abrasion resistance.

Product Descriptions

Product Name	Description	Application	Maximum No. of Passes
VX-GP	Buildup on typical carbon steels	Great for general-purpose buildup. Easily machinable deposit for use on most carbon steels. Can also be used for joining.	Unlimited
VX-MP	Buildup on all types of steels	Very versatile buildup and buffer layer for all types of steels. Will work-harden to Rc 40 to Rc 47. Can also be used for joining	Unlimited
VX-H1	Austenitic Manganese CrMnC – 15/15/0.5	A work-hardening product intended for extreme impact with little or no abrasion. Will work-harden to Rc 47 to Rc 50.	Unlimited
VX-H3	Martensitic Rc 50 to Rc 65	For applications where there is significant impact and abrasion. Extremely versatile product.	Unlimited
VX-H4	Boron carbide BMnC – 4.5/2/.5	A chromium-free, carbide-bearing product that may relief check with multiple passes. Good for abrasion and significant impact.	Four
VX-H5	Low chrome carbide CrC – 16/3	A carbide-bearing product that will relief check with multiple passes. Good for abrasion and moderate impact.	Three to four. Will typically relief check after one.
VX-H6	Low carbide, fine particle CrTiC – 7/5/2	A carbide-bearing product that will rarely relief check with single pass deposits and is great for fine particle abrasion applications. Will take a significant amount of impact.	Three to four. Will typically relief check after one.
VX-H7	Moderate chrome carbide CrC – 24/4	A moderate carbide-bearing product that will relief check. Good for significant abrasion with low impact.	Three
VX-H10	Complex carbide	The longest-lasting carbide-bearing product in pure abrasion applications.	Two

All products listed are self-shielding, flux-cored wires.