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Since 1975

Wexco inlay to screw material compatibility guide

| Flight Hard surface | Coating/Treatment | Compatible Inlay Material | | | | |
|---------------------|-----------------------|---------------------------|-----|--------|----------|------|
| | | 555 | 666 | 686 XL | 777 Duro | B022 |
| Stellite 6/12 | chrome | | X | X | | |
| Colmonoy 56 | chrome | X | X | X | X | X |
| Colmonoy 57 | chrome | | X | X | X | |
| Colmonoy 83 | chrome | | | | X | |
| Colmonoy 88 | chrome | | | | X | |
| CPM9V tool steel | hardened | | | X | X | |
| CPM10V tool steel | hardened | | | | X | |
| CPM-M4 tool steel | hardened | | X | X | X | |
| CPM T440 tool steel | hardened | | | X | X | |
| CPM T420V SS90V) | hardened | | | X | X | |
| Elamax | hardened | | | | | |
| D2 tool steel | Heat treated | | | | X | |
| H13 | Heat treated | | X | X | X | |
| Nitraloy 135 M | Nitride | | X | X | X | |
| 4140 Flame Hardened | Chrome | X | X | X | X | |
| XC1000 HVOF | carbide encapsulation | | | | X | |
| XC4000 HVOF | nickel encapsulation | | | | X | X |
| LW-1N30 | UCAR encapsulation | | | | X | |
| Inconel | age hardened | X | | | | X |

There are a substantial number of different feed screw constructions engineered to meet process demands. Popular options include flight land hard surfacing such as Stellite (6 & 12), Wall Colmonoy (C56, 57, 83, 88) or similar PTA and spray weld applied materials. Other alloys include machine grade tool steels that are through hardened, nitrided, heat treated, flame, induction, precipitation or age hardened. In most instances the screws base metal is hardened, coated or otherwise treated to enhance hardness and durability of the flight land and root. It is the responsibility of the screw manufacturer to achieve the appropriate flight surface hardness necessary to prevent galling between the barrel and screw. CPM is a trade name of the Crucible Corporation

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