

HARDFACE CNV-E

CLASSIFICATION

EN 14700 : E Fe16

DIN 8555* : E10-UM-65-GRZ

Former classification replaced by EN 14700

DESCRIPTION

- High chromium cast iron with extra alloying additions for hardsurfacing components subject to extremely severe abrasive wear at high temperatures
- The deposit contains a high proportion of hard primary chromium and complex carbides in a tough secondary carbide eutectic matrix
- Maintains its abrasion resistance up to 550°C
- Very high recovery rate: 200%

APPLICATIONS

Hardface CNV-E is designed to give a weld deposit of particularly high hardness and wear resistance on account of the dispersion of complex carbides it contains. This gives superior performance compared to standard chromium cast irons. Relief checking is normal.

Examples

Ore sintering, crushing, riddling, blast furnace hoppers and throats, screw conveyors, manufacture of cement and ceramics.

TYPICAL ALL-WELD METAL ANALYSIS

C	Si	Cr	Mo	Nb	W	V
5.0	1.5	22	7	7	2	1

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness 3-layers deposit on mild steel: ~ 65 HRc

OPERATING CONDITIONS

Electrode ØxL [mm]	3.2x350	4.0x450	5.0x450
Current [A]	110-140	140-190	190-250

Redrying, if necessary, 2h/300°C. Guide electrode almost vertically with a short arc and a slight weave. Keep the welding current low to minimize dilution from the base material.

= + 50 V

WELDING POSITIONS			
1G/PA			
PACKAGING			
Electrode ØxL [mm]	3.2x350	4.0x450	5.0x450
Weight/box [kg]	4.5	6.0	6.0
Piece/box	64	41	27