

CLASSIFICATION

EN ISO 17653 A : T Z 18 10 9 CrCoMn MM2

EN 14700 : Outside standard

DESCRIPTION

- Cored wire for gas shielded metal arc hardfacing
- Specially developed for cavitation resistance
- Good erosion resistance thanks to its nitrogen content creating fine precipitation of hard nitrides
- Austenitic deposit with excellent work hardening properties

APPLICATIONS

- CAVITALLOY N28-G is used for protection of surfaces subjected to combined cavitation, corrosion and erosion in liquid media.

Examples:

Hydro-turbines (TurboAlternator, Kaplan and Francis type). Pumps for various liquids in industry, agriculture and water distribution. Valves and ducts for liquids. Propellers.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness - 3 layers deposit

As welded: 95 HRB

CONDITIONS OF USE

Current type

Shielding gas

DC (+) / DCEP	EN 439	M11: Ar + 2 - 5% CO ₂
		M12: Ar + 2 - 3% O ₂
		M21: Ar + 5 - 25% CO ₂

OPERATING CONDITIONS

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.3	100 - 250	200	19 - 33	28	12 - 25	20
1.6	180 - 320	250	19 - 33	28	12 - 25	25

Recovery: 95 %

WELDING POSITIONS

CAVITALLOY N28-G, up to Ø1.6mm, is as suitable for down hand as positional welding by adapting transfer mode and welding parameters as for solid wires

STANDARD DIAMETERS (mm)

1.3, 1.6

Other diameters: please consult us

PACKAGING

Diameter	1.3 mm	1.6 mm
Standard packaging [EN ISO 759]	Spool : BS 300	Spool : BS 300
Weight	15 kg	15 kg