

HARDFACE 167Nb-S

CLASSIFICATION

EN 14700 T Fe6

DESCRIPTION

- Tubular wire for submerged arc hardfacing
- Designed for hardfacing of items subjected to impact, gouging and abrasion under high stress
- Gives a highly abrasion-resistant crack-free deposit which may be machined despite its high hardness
- Suitable for multi-layer deposits

APPLICATIONS

• Hardface 167Nb-S is designed for hardfacing of pieces subjected to extreme wear conditions. The deposit contains no cracks or pores yet possesses the exceptional hardness and abrasion resistance of a chromium cast iron product.

• The product is used for items that must resist wear while withstanding impacts and very high stress levels: crushing hammers and rollers, leading edges and teeth of excavator buckets, bulldozer blades, rotary crusher cones etc. Also used in applications such as oil press tooling, where tight tolerances must be maintained under abrasive conditions.

TYPICAL ALL-WELD METAL STRUCTURE

Structure: martensite with finely dispersed niobium carbide particles

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3 Layers deposit: as welded 55 - 60 HRc

CONDITIONS OF USE

Current type		Shielding	
DC (+)		WAF 325	
FLUX DESCRIPTION		WAF 325	
Classification		EN 760: S A AB 1 65 DC H5	
Redrying	2 hours at 250°C ± 50°C		
Packaging	bags (25 kg)		

OPERATING CONDITIONS

Diameter	Amperage [A]	Voltage [V]	Stick-out [mm]
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[mm]	Range	Optimum	Range	Optimum	Range	Optimum
2.4	200 - 450	350	26 - 32	30	25 - 50	30
2.8	250 - 550	400	28 - 32	30	25 - 50	30
3.2	300 - 650	500	28 - 32	30	25 - 50	30

Recovery: 95 %

WELDING POSITIONS

Flat

STANDARD DIAMETERS (mm)

2.4, 2.8, 3.2

Other diameters: please consult us

PACKAGING

Diameter	2.4 mm		2.4 mm	
Standard packaging	Spool EN759 : BS 300		Coil	Drum
Weight	15 kg		25 kg	Up to 330 kg