

HARDFACE NICARBW

CLASSIFICATION

EN 14700 T Ni20

DESCRIPTION

- Flux cored hardfacing wire containing 50 to 60% tungsten carbides (according to wire diameter)
- Ni-Cr-B-Si matrix
- Optimised combination of toughness and wear resistance due to the heterogeneous weld metal composed of tungsten carbides distributed in a hard and very tough matrix
- Excellent wetting characteristics

APPLICATIONS

Applications requiring extreme abrasion resistance combined with corrosion resistance.

Examples

Brick and clay mill augers, earthmoving equipment (such as plows), rubber mixers and generally all parts undergoing severe abrasion in the mining, steelmaking and public works.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: Tungsten carbide: 2360 HV

Ni-Cr-B-Si matrix: 500 - 600 HV

CONDITIONS OF USE

Current type

DC (+)

Protection

Shielding gas type M21 (Ar + 5-25%CO₂)

Self shielded

Select high strength base materials

Surfaces to be welded should be free of rust, scale, oil or any other contamination, work with low heat input to avoid melting or sinking of the tungsten particles

OPERATING CONDITIONS

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.6	120 - 180	150	19 - 22	21	25 - 40	30

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
2.0	130 - 190	170	20 - 21	21	25 - 40	30
2.4	220 - 280	260	21 - 23	21	25 - 40	30
2.8	280 - 350	320	20 - 21	21	25 - 40	30

Recovery: 95 %

WELDING POSITIONS

Flat, downhand

STANDARD DIAMETERS (mm)

1.6, 2.0, 2.4, 2.8

Other diameters: please consult us

PACKAGING

Diameter	2.4 mm		2.4 mm
Standard packaging [EN ISO 544]	Spool : BS 300	Coil : B 450	Drum
Weight	15 kg	25 kg	Up to 330 kg