

## ABRAWELD ULTRA WSC Ni

Electrodes MMA [SMAW]

Hardfacing and repairing

<b>CLASSIFICATION:</b>	<b>APPROVALS:</b>	<b>APPLICATION:</b>
EN ISO 14700-A : E Ni20 cg DIN 8555 : E 21-GF-50-CG		Hardfacing and repairing Mining

- Tubular hardfacing electrode containing tungsten carbides based on NiBSi matrix.
- Creates an extremely hard matrix with embedded tungsten carbides.
- Overlay weld matrix based on NiBSi with a hardness of approx. 45-50HRC, and the hardness of tungsten carbides is approx. 2300 HV.

### Recommendations:

It is not recommended to pad base materials with a carbon content above 0.45%. To obtain the best results, hardfacing surfaces should be cleaned of rust, grease and other dirt. To avoid melting the carbides, use as little line energy as possible. It is possible to supply the electrode with different grain sizes, depending on the application.

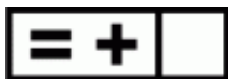

### Application

It is used where there is extreme abrasive wear combined with corrosion media. Surfacing of machines and devices working in drilling and mining. In machine elements exposed to severe abrasion, especially of the mineral type. Mixers, grinding plates, screw conveyors, slurry pump valves. Molding sand preparation installations.

### Typical chemical composition %

<b>Ni</b>	<b>Inne</b>
NiSiB - ok. 37	WSC - ok. 63

### Typical mechanical properties

<b>Hardness</b>	NiSiB matrix - app. 45 - 50HRC / Cemented tungsten carbides > 2300HV /
<b>Coating type</b>	tubular
<b>Welding current</b>	
<b>Welding positions</b>	

### Welding parameters and packing

ø	Length [mm]	Welding current [A]	Weight of packet [kg]	Pcs/1 kg
4,0	350 /	80 - 100	5,0	66
5,0	350 /	100 - 120	5,0	42
6,0	350 /	120 - 160	5,0	20

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