# COREWELD NiCrBWSC

Flux cored wires [FCAW]

Hardfacing and repairing

| CLASSIFICATION: | APPROVALS: | APPLICATION: |
|---|---|---|
| EN ISO 14700-A : T Ni20<br>DIN 8555 : MF 21-GF-55-CGTZ | | Hardfacing and repairing |

- Hardfacing flux cored wire containing fused tungsten carbides in a nickel base matrix alloy.
- The weld metal is composed of 63% fused tungsten carbides which are embedded in 37% matrix alloy containing NiSiB.
- This wire produces smooth and clean surface, thanks to the low melting point of between 900 and 1000°C the alloy flows very well.
- The nickel based matrix alloy provides excellent resistance to acids and the other corrosive media.
- Recommended for use in materials exposed to extreme wear and simultaneous exposure to corrosive factors.

**Recommendations:**

- The welded material needs to be cleaned and free from grease, scale, corrosion, etc.
- The preheating temperature between 300°C - 500°C.
- The base material can be heated during the welding process till 650°C, however overheating should be avoided.

## Application

Parts and equipment made of ferritic and austenitic steels, f.ex. mixer blades,milling plates, conveyor worms, stabilizer blades, slurry pump valves, moulding sand preparation plants, in the chemical, drilling, wood processing and food industries.

## Typical mechanical properties

| | |
|---|---|
| **Hardness** | Fused tungsten carbide >2300 HV / Matrix: 47 HRC / |
| **Welding current** |  |
| **Shielding gases acc. to EN ISO 14175** | M13 - Ar + 0.5 - 3% O2 / |
| **Remarks** | Weld metal analysis (typical values, %): NiSiB matrix: approx. 45 WSC: approx. 55 |

## Welding parameters and packing

| ø | Weight of packet [kg] |
|---|---|
| 1,6 | 15,0/30,0 |
| 2,0 | 15,0/30,0 |
| 2,4 | 15,0/30,0 |
| 2,8 | 15,0/30,0 |

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