

<b>Technical data sheet</b>  <small>090121MBA</small>	<b>Cored Welding Wire</b>  <b>HARDFACE NICARBW</b>	 <b>Welding Alloys</b>
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## CLASSIFICATION

EN 14700 : T Ni20

## DESCRIPTION

- Flux cored hardsurfacing wire for gas shielded or self shielded processes
- Contains approximately 60% fused tungsten carbides
- Optimised combination of toughness and wear resistance due to the heterogeneous weld metal structure composed of tungsten carbides distributed in a hard and very tough nickel base matrix
- Excellent wetting characteristics
- The matrix is highly resistant to corrosive media

## 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 CHARACTERISTICS – ALL-WELD METAL

Bulk hardness: 45 - 55 HRC  
Tungsten carbides: 2000 - 2800 HV  
Ni matrix: 400 - 550 HV

## CONDITIONS OF USE

Current type	Protection
DC+	I1: 100% Ar M12: Ar + 0,5 - 5% CO <sub>2</sub> M21: Ar + 15 - 25%CO <sub>2</sub> Self-shielded

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 should be favoured

## OPERATING CONDITIONS

### Gas shielded

Diameter [mm]	Current [A]	Voltage [V]	Stick-out [mm]
1.6	110 - 160	16 - 20	12 -25
2.0	130 - 190	22 - 27	12 -25
2.4	150 - 230	22 - 28	12 -25
2.8	170 - 280	22 - 30	15-30

Recovery: 98 %

## WELDING POSITIONS

Flat, half up, half down

## PACKAGING

Diameter	≤ 2.4 mm	≥ 2.4 mm	
Standard packaging	EN ISO 544: BS 300 spool	B 450 coil	Drum
Weight	15 kg	25 kg	Up to 330 kg

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.