

Technical data sheet <small>080122MBA</small>	Cored welding wire ROBODUR K NB-G	 Welding Alloys
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CLASSIFICATION

EN 14700: T Fe6

DESCRIPTION

- Seamless copper coated tubular wire for semi-automatic or automated gas shielded metal arc hardfacing
- Produces a hard overlay resisting abrasion and impact
- Finely dispersed hard carbide phases optimise anti-wear properties
- User friendly for welding multiple pass welds as there is no hinder from slag

APPLICATIONS

- ROBODUR K NB-G is designed for hardfacing of items subjected to impact, gouging and abrasion under high stresses. It gives a highly abrasion-resistant crack-free weld metal and is suitable for multi-layer deposits.

Examples

Crushing hammers and rollers, leading edges and teeth of excavator buckets, bulldozer and scraper blades, rotary crusher cones, dipper teeth, etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Nb	Fe
1.5	0.8	0.8	6.5	6.0	Bal.

Structure: martensite with finely dispersed niobium carbide particles.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness - 3 layers on mild steel: 56 HRC

SHIELDING GAS

Current type*	Shielding gas	
DC-, DC+	EN ISO 14175	M21: Ar + 15-25% CO ₂ M20 (Ar + 5% < CO ₂ ≤ 15%) M12: Ar + 0.5 - 5 % CO ₂

*Pulsed mode is possible

OPERATING CONDITIONS

Diameter [mm]	Current [A]	Voltage [V]	Stick-out	Gas flow rate
1.2	250-300	27-30	12 - 20 mm	15 - 20 l/min.
1.6	280-350	27-30	12 - 20 mm	15 - 20 l/min.

Recovery: 98%

WELDING POSITIONS

ROBODUR K NB-G is suitable for both downhand and positional welding by adapting transfer mode and welding parameters as for GMAW with solid wires.

PACKAGING

Diameter	1.2 mm	1.6 mm
	EN ISO 544 – ASME II C SFA-5.2 M	
Spool type	BS300	
Weight	15 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.