

Technical data sheet <small>011121MBA</small>	Cored welding wire ROBODUR K CERAMIC-G	 Welding Alloys
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CLASSIFICATION

EN 14700: T Fe8

DESCRIPTION

- Seamless copper coated tubular wire for semi-automatic gas shielded hardfacing
- Martensitic weld metal contains finely dispersed hard carbides ensuring an optimal balance between abrasion, metal to metal wear and impact resistance
- No moisture-pick up with excellent wire feeding properties
- Unique welder appeal

APPLICATIONS

- ROBODUR K CERAMIC-G is specially designed for hardfacing new or worn ceramic moulds.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr
0.35	0.7	2.5	9.5

Microstructure: martensite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Current type	Hardness - First layer	Hardness - Third layer
DC+	52 – 55 HRc	55 – 60 HRc
DC-	55 – 57 HRc	57 – 62 HRc

CONDITIONS OF USE

Current type	Shielding gas	
DC-, DC+ or pulsed	EN ISO 14175	M12: Ar + 0.5 – 5 % CO ₂ With or without He
		M13: Ar + 0.5 - 3% O ₂
		M21: Ar + 15 – 25 % CO ₂

OPERATING CONDITIONS

Diameter [mm]	Current [A]	Voltage [V]	Stick-out	Gas flow rate
1.2	80 - 300	15 - 32	12 - 25 mm	10 - 20 l/min.
1.6	130 - 350	16 - 32	12 - 25 mm	10 - 20 l/min.

Recovery: 98 %

WELDING POSITIONS

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

PACKAGING

Diameter	1.2 mm	1.6 mm
	EN ISO 544 – ASME IIC 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.