CEWELD®

Dur RU (Ni)

CATEGORY	SMAW Stick Electrodes
TYPE	NiCrBSi based SMAW electrode filled with tungsten carbides for extreme wear resistant overlays.
APPLICATIONS	The main applications are hardfacing and rebuilding of stabilisers and other oilfield tools where maximum protection is required. Also for augers, impellers, mixer plates in the brick and clay industry and on decanter screws in the food and chemical industry where corrosion resistance is needed. DUR RU (Ni) can be applied on all sorts of steels except on cast iron or Mn-steel. This alloy is the most wear resistant type in most hardfacing applications. In case of very fine dust abrasion It might happen that the matrix will be washed out and looses the imbedded Tungsten carbides, in this case another hardfacing product should be considdered..
PROPERTIES	**Dur RU(Ni)** is a coated flux-cored tube for electric welding, a newly designed hard-surfacing product consisting of crushed tungsten carbide and a Ni-based alloy. Crushed cast carbide will guaranty a long life. Furthermore the Ni-based alloy provides an excellent corrosion resistance. **Dur RU (Ni)** has excellent welding and wetting characteristics at very low currents. It is easy to use and inexperienced welders will have no difficulties to produce smooth deposits mainly without cracks. Multi-layer deposits are possible and worn parts can be rebuild without removing the old material**. Dur RU (Ni)** can be applied on all sorts of steels except on cast iron or Mn-steel.
CLASSIFICATION	AWS A 5.13: no class EN ISO 14700: E Ni20 DIN 8555: E21-GF-UM-60-CGZ
SUITABLE FOR	Scratchers, mixers, deep drilling, bentonit mixers, cement mixers, stabilisers, impellers, augers etc.
APPROVALS	CE approved
WELDING POSITIONS:	

Ni + Cr + B + Si (Matrix)	Crushed tungsten carbides (WC2)
Rem	65%

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (N/mm²)	Rm (N/mm²)	A5 (%)	Impact Energy (J) ISO-V -20°C	-40°C	Hardness Matrix	Carbides
						500 HV	2360 HV

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) (DC+/AC)	kg / can	kg / 6pack	kg / 1000
4.0	350	100	5	30	
5.0	350	120	5	30	
6.0	350	160	5	30	
8.0	350	160	5	30	

REDRYING TEMPERATURE	not required
PARTICLE SIZE	Tungsten particle sizes are standard 0,2-0,5 mm (other sizes are available on request)