

AA NiCrSiB

CATEGORY	FCAW Flux-Cored
TYPE	High-alloyed tubular wire on a Ni-Cr-Si-B basis for high wear protection in several applications.
APPLICATIONS	The characteristics of the deposit are comparable with cobalt-base alloys but with higher hardness, excellent corrosion resistance, heat resistance and thermal shock constancy.
PROPERTIES	Very good corrosion resistance combined with high hardness even at higher temperatures. Excellent weldability and often used as economical alternative for „stellite“

CLASSIFICATION	EN ISO	14700: T Ni 1-60-CGTZ
	DIN	8555: MF 22-60-CGTZ

SUITABLE FOR	rotary seal rings, pumps, sleeves, grinder parts, chemical and glas industry.
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APPROVALS	CE approved
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WELDING POSITIONS:	
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WELD DEPOSIT WEIGHT %

C	Si	Cr	B	Fe	Ni
0.75	4.2	13,5	3	<5	Rem

MECHANICAL PROPERTIES OF THE PURE WELDING DEPOSIT

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc
				-20°C	-40°C	-60°C	
AW							55-60

AW: as welded

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		spool type	Packing	
	Voltage (V)	Current (A)		kg / spool	kg / pallet
1.2	18-26	120-200	K-300 / Drum	15 / 250	1080 / 1000
1.6	20-26	160-260	K-300 / Drum	15 / 250	1000 / 1080
2.4	26-29	230-350	K-415 / Drum	25 / 250	950 / 1000

REDRYING TEMPERATURE	150°C / 24hr
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GAS ACC EN ISO 14175:	1I, (Argon + 1% O2)
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