

Technical data sheet

150222JMBA

Cored welding Wire

HARDFACE NCWB**CLASSIFICATION**

EN 14700: T ZFe8

DESCRIPTION

- Cored wire for gas shielded or self-shielded metal arc hardfacing
- The deposit is a complex alloy containing chromium, tungsten, boron, niobium and molybdenum
- Extreme abrasion resistance against high stress grinding abrasion and erosion without impact
- High hardness (66 - 70 HRC) and abrasion resistance are achieved on first layer
- Recommended for single layer deposition, also applicable in 2 layers
- Re-applicable on previous hardfacing overlays produced with NCWB

APPLICATIONS

HARDFACE NCWB is used for application requiring extreme abrasion resistance, moderate impact and/or elevated temperature (up to 750°C).

Examples:

Excavator buckets, crusher, extrusion screws, shredders, hammers, fan blades, sinters.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	W	Nb	B	Fe
1.1	0.6	0.7	21.5	4.1	6.7	3.6	+	Bal.

Structure: Complex carbides and borides homogeneously dispersed in an austenitic matrix.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 66 - 70 HRc.

OPERATING CONDITIONS**Gas shielded**

Diameter [mm]	Polarity	Amperage [A]	Voltage [V]	Stick-out [mm]	Gas flow rate [l/min]
1.2	DC+	150 - 200	24 - 30	20 - 25	15 - 20
1.6	DC+	170 - 220	24 - 30	20 - 25	15 - 20

Self-shielded

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	100 - 300	250	21 - 35	28	25 - 50	25
1.6	150 - 350	270	24 - 35	28	25 - 50	25
2.0	200 - 400	300	26 - 35	28	25 - 50	35
2.4	250 - 450	350	26 - 35	28	25 - 50	40
2.8	250 - 450	400	28 - 35	30	25 - 50	40

Recovery: 95 - 99 %

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.