

CORODUR[®] NiCrMo 22

CLASSIFICATION:

DIN EN 14700 DIN 8555
T Fe13 MF 1-300-P

GENERAL CHARACTERISTICS:

CORODUR NiCrMo 22 is a flux cored wire which is suitable for medium alloyed steels and high strength steels. This alloy can also be used as a buffer and build-up layer (multiple pass). When NiCrMo 22 is used as buffer and build-up layer for rolls and parts followed by a hard surfacing alloys, the preheat and interpass temperature should be chosen depending of the C-contents of the base material). The weld deposit is highly crack resistant and is highly resistant to impact and pressure wear.

APPLICATION:

Build-up layers for carbon steels, buffer layers for continuous casting rolls and Cement Rolls.

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Cr	Ni	Mo
0,06	0,6	1,6	0,4	2,2	0,5

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 280 - 320 HB

PARAMETER:

Diameter	Voltage	Amps
1,2	20 - 24	150 - 200
1,6	22 - 26	180 - 240
2,0	25 - 27	220 - 260
2,4	25 - 27	260 - 300
2,8	26 - 28	280 - 340

FORMS OF DELIVERY:

Coil "BS 300" = 15 kg | Coil "BS 450" = 25 kg | Drums = 300 kg

OA = gasless, G = gas shielded, SA = Submerged Arc