

Supershield CrCNb

Cr-Carbide+Nb-Carbide Type

Conformances

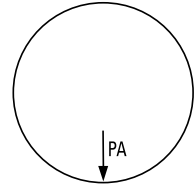
Applications

- Cement roll mill, bucket teeth and lips, crusher and coke hammers, wear plate

Features

- Open arc type hardfacing wire
- Cr-Carbide + Nb-Carbide type

Welding Position



Current

DC +

Welding Process

Open Arc

Diameter / Packaging

Diameter	Spool		Coil	Pac		
	12.5kg (27.6lbs)	15kg (33lbs)	25kg (55lbs)	150kg (330lbs)	250kg (551lbs)	350kg (771lbs)
1.2 (0.045)						
1.6 (1/16)		✓				
2.4 (3/32)						
2.8 (7/64)			✓	✓	✓	
3.2 (1/8)						

SM/W

SAW

GM/W

GT/W

FC/W

Non-FERROUS

APPENDIX

Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	P	S	Cr	Nb
As welded with 1.6mm wires	4.5	0.7	0.2	0.015	0.003	21.0	6.5
As welded with 2.8mm wires	5.0	0.8	0.2	0.011	0.004	22.0	6.8

Typical Mechanical Properties of All-Weld Metal

		Rockwell Hardness(HRc)		
		1 Layer	2 Layers	4 Layers
On Mild Steel	1.6mm	-	-	60-64
	2.8mm	-	-	62-65

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
1.6mm (1/16 in) DC+					
Open Arc	25 (1)	5.0 (196)	250	28	3.5 (7.7)
		7.5 (295)	300	29	6.0 (13.2)
		11.5 (452)	350	32	7.8 (17.2)
2.8mm (7/64in), DC+					
Open Arc	25 (1)	2.9 (117)	330	28	5.2 (11.4)
		3.7 (146)	380	29	6.4 (14.1)
		4.4 (174)	430	30	7.3 (16.0)