CEWELD®

AA NiCrSiB 40

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 and offers 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“. The alloy is spark free and non magnetic.
CLASSIFICATION	EN ISO 14700: T Ni 1-45-CTZ DIN 8555: MF 22-45-CTZ
SUITABLE FOR	rotary seal rings, pumps, sleeves, food industry, nuclear, screw conveyors, winches.
APPROVALS	CE approved
WELDING POSITIONS:	

WELD DEPOSIT WEIGHT %

C	Si	Cr	B	Fe	W	Ni
0.35	4.5	22	1.6	<5	2	Rem

MECHANICAL PROPERTIES OF THE PURE WELDING DEPOSIT

Heat Treatment	$R_{P0,2}$ (N/mm²)	Rm (N/mm²)	A5 (%)	Impact Energy (J) ISO-V -20°C	-40°C	-60°C	Hardness HRc
AW							39-42

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	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
GAS ACC EN ISO 14175:	I1, (Argon + 1% O2)