

## Colmonoy 4

<b>CATEGORY</b>	GMAW-GTAW Solid wires						
<b>TYPE</b>	Nickel based Tig filler metal for hardfacing and overlay applications.						
<b>APPLICATIONS</b>	Colmonoy® 4 offers outstanding metallurgical and physical properties making them ideally suited to solving wear mechanisms such as abrasion, erosion, corrosion and high-temperatures encountered in service.						
<b>PROPERTIES</b>	This nickel based alloy offers superior wear protection, retaining its hardness up to 600°C (1000°F) with significant resistance to oxidation.						
<b>CLASSIFICATION</b>	AWS	A 5.14: AMS:					
	EN ISO	18274:					
<b>SUITABLE FOR</b>	Aircraft gas turbines, steam turbine powerplants, turbochargers and valves in reciprocating engines, prosthetic devices, heat treating equipment, pollution control equipment, coal gasification and liquefaction systems, and components in pulp and paper mills.						
<b>APPROVALS</b>	CE approved						
<b>WELDING POSITIONS:</b>							
<b>ALL WELD METAL ANALYSIS % (TYPICAL)</b>							
C	Ni	Cr	B	Si	Fe		
0.4	Bal	10	2.1	2.4	2.8		
<b>NOMINAL MECHANICAL PROPERTIES (AS WELDED)</b>							
Working temperature	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness H <sub>Rc</sub>
				20°C	-40°C	-60°C	
							35-40
<b>AW: as welded</b>							
<b>WELDING PARAMETERS / PACKING</b>							
D (mm)	Welding Parameters			Voltage (V)	Packing (kg)		
	Current (A) DC-				single	master	
2,4	100-200			11-14	5	25	
3,2	120-250			11-14	5	25	
4,0	150-280			10-12	5	25	
5,0	180-300			9-11	5	25	
<b>REDRYING TEMPERATURE</b>	not required						
<b>GAS ACC EN ISO 14175:</b>	I1						