CEWELD®

Dur CE-Tube WC2

CATEGORY SMAW Stick Electrodes

TYPE Tubular hardfacing electrode with C-Cr-Co-Zr-Al-WC2 carbides.

APPLICATIONS This electrode offers a extreme recovery and can be used for overlays with extremely abrasive wear resistance, but with low impact. 3 layers should be considdered as maximum.

PROPERTIES Due to the complex carbide combination of Cobalt, Chromium, Aluminium, Zirconium and a extreme high Tungsten content the wear resistance against abrasion is 4 till 8 times better in comparison with C-Cr. alloys. Hard facing knowledge is based on practical experience and years of testing many different procedures and alloys. For your typical application we recommend to consult us for a tailor made welding procedure in order to achieve the best possible results for each job.
1) up to 3 times faster ! (less current with more deposit)
2) No slag losses compare to 40% loss with standard electrodes.!
3) Low amperage offers much lower heat input ! (see point 1)
4) 6 mm is ideal to weld in position and on sharp edges !
5) Moisture resistant coating even in extreme humidity conditions !

CLASSIFICATION

AWS	A 5.13: no standard
EN ISO	14700:
DIN	8555: E 21 – GF – 65 –GZ

SUITABLE FOR Sinter plant parts, Swing hammers, Drilling surfaces, Stone crushers, Fan blades, Coke pusher shoes and crushers segments, Shovel, Cement mill parts, Earthmoving equipment, etc.

WELDING POSITIONS:

MAIN WELD DEPOSIT COMPOSITION (CARBIDES)

WC2	Cr	C	Fe	Co	Al	Mn	Zr	P
+	+	+	+	+	+	+	+	+

MECHANICAL PROPERTIES

Nr. Of layers On mild steel	RP0,2 (N/mm2)	Rm (N/mm2)	A5 (%)	Impact energy (J) ISO-V -20C	-40°C	-60C	Hardness HRc
1 layer							62-64
2 layers							65-70

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters		
D (mm)	Length (mm)	Current (A)
6.3	450	75-130

REDRYING TEMPERATURE not required