



NI-WC

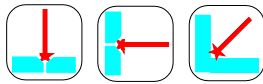
EN 14700 T Ni20

DESCRIPTION

Meltolit NIWC is a flux cored wire with fused tungsten carbides (50-62%) and a NiCrBSi matrix for semi automatic applications. Protects surfaces against extreme abrasion combined with corrosion attacks. The matrix is resistant to acids, bases, lye and other corrosive media. Repairing and hardfacing ferritic and austenitic steels.

Applications: Mixer blades, scrapers, mining and drilling equipment, crushers, tool joints in petroleum industry etc

WELDING POSITIONS



CURRENT TYPE

DC(+)

GAS

I1, (M13, M12)

MECHANICAL PROPERTIES

Hardness

FTC: Approx 2360 HV

NiCrBSi Matrix: Approx 50-55 HRC

PACKING INFORMATION AND WELDING PARAMETERS

Dimension(mm)	1,2	1,6	2,4	2,8
Spool(kg)	15	15	15/25	15/25
Stick-out(mm)	25-40	25-40	25-40	25-40
Amperage(A)	120-160	120-180	200-230	220-260
Voltage(V)	16-20	19-22	21-23	21-23

The area to be welded need to free of rust, scale, oil and other contamination. Do not overheat the base material and choose as low heat input as possible to avoid decomposition of the carbides. Choose high strength base material.