

DIN EN 14700

T Fe 20-65-GZ

## COROCARB Fe

COROCARB is an open arc tubular wire filled with fused tungsten carbide (FTC) for semi-automatic application, where extreme abrasive wear is encountered. For hardfacing of low alloyed steels that have a maximum of 0,45% carbon (a higher carbon content could lead to cracking). Also used for hardfacing and repairing tools and machine parts exposed to wear. The area to be hardfaced should be free of rust,

scale, grease or other dirt. Depending on the base metal's alloy and the size of the area to be hard-faced, the advisable preheating temperature should be between 350-500 °C (662-932 °F). If the voltage and the welding current are kept on the lowest setting possible the tungsten carbide granular will be prevented from melting. During welding, position the arc that the weld metal is deposited in coarse droplets.

Mining, excavation, earth moving, tunneling shields, road construction, well drilling and deep drilling.

### TYPICAL ALL WELD METAL ANALYSIS (%)

Fe-C-W-Matrix + 62% FTC

Hardness HRc

Matrix 65

2400 HV<sub>0,2</sub>

### PARAMETER

Diameter	Voltage	Amps
1,2	22 - 26	140 - 180
1,6	22 - 26	160 - 200
2,0	24 - 26	180 - 240
2,4	24 - 27	220 - 260
2,8	24 - 27	240 - 280

Other dimensions on demand

### FORMS OF DELIVERY

Unit	Weight
Coil BS 300	15 kg
Coil B 450	25 kg
Drums	300 kg

G = Gas shielded, OA = Open Arc,