

## COROCARB NI-PLUS

**CLASSIFICATION:** Flux-Cored Wire DIN-EN 14700 — T Ni 20-55-CGZ

**GENERAL CHARACTERISTICS:** **COROCARB NI-PLUS** is a cored metal wire filled with Ni-Cr-B-Si and spherical fused tungsten carbide (**SFTC**).  
**COROCARB NI-PLUS** was developed to protect surfaces where extreme abrasive wear in combination with corrosion are encountered.

**APPLICATIONS:** Repairing & hardfacing ferritic and austenitic steel tools and machine parts (steel castings) in the chemical industry and food industry. Stabilisers in the petroleum industry, mixer blades, conveyors and screws in the chemical and dye industry as well in the food processing industry.

**RECOMMENDED WELDING DIRECTIONS:** The area to be hardfaced should be free of rust, scale, oil and other dirt. Be sure that the base material is not overheated and choose amps and volts as low as possible to avoid melting the **SFTC**.

**TYPICAL HARDNESS:** SFTC: > 3.000 HV  
Matrix: approx. 450 – 480 HV<sub>0,1</sub>

| SIZES AVAILABLE AND CURRENT SETTINGS |        |                              |             |           |
|--------------------------------------|--------|------------------------------|-------------|-----------|
| Ø mm                                 | Ø inch | Coil Size<br>DIN EN 759      | Amps        | Voltage   |
| 1,6                                  | 1/16   | BS 300<br>cages ca. 15<br>kg | 160 - 180 A | 18 – 20 V |
| 2,4                                  | 3/32   | B 435<br>cages ca. 25<br>kg  | 200 - 230 A | 21 – 23 V |