

COROCARB–NIA-PLUS

CLASSIFICATION: Stick Electrode DIN-EN 14700 — T NI 20-55-CG

GENERAL CHARACTERISTICS: **COROCARB–NIA-PLUS** is a cold rolled, formed, closed seam nickel tube filled with spherical fused tungsten carbide (**SFTC**) and Cr, B and Si for oxyacetylene application. The deposited alloy consists of approximately 65% SFTC and 35% Ni-Cr-B-Si-matrix. **COROCARB–NIA-PLUS** wets easily and has excellent flow producing a smooth, clean surface. **COROCARB–NIA-PLUS** has a low melting point of approx. 900 – 1050°C. The overlay is extremely resistant to acids, bases, lye's and other corrosive media and other excessive wear conditions.

APPLICATIONS: Hardfacing on ferritic and austenitic steels (steel casings), overlaying mixer blades and conveyors & screws in : chemical & dye industry and food industry. Recommended for hardfacing rock bits and stabilizers in the petroleum industry.

RECOMMENDED WELDING DIRECTIONS: The surface to be hardfaced should be clean and free of rust, scale or grease and other dirt, preferably by grinding or shot blasting. Deposits should be made using a gas flame with a neutral to slight acetylene excess. To avoid puddling and overheating, sweat deposits on the base metal with minimum penetration.

TYPICAL HARDNESS: SFTC: > 3000 HV
Ni-Cr-B-Si-Matrix: approx. 450 - 520 HV_{0,1}

| SIZES AVAILABLE : | | | | | |
|-------------------|------|--------|---------------|--------------|-------------|
| Type | ø mm | Ø inch | grain size mm | US mesh size | Colour code |
| 4005 | 4,0 | 5/32 | 0,25 – 0,84 | 20 – 60 | white |
| 5005 | 5,0 | 3/16 | 0,25 – 0,84 | 20 – 60 | white |
| 6005 | 6,0 | 1/ 4 | 0,25 – 0,84 | 20 – 60 | white |

Standard tube metal length: 700mm (28")