COROCARB–NISE

CLASSIFICATION: Stick Electrode DIN-EN 14700 — E Ni 20-60-CGZ

GENERAL CHARACTERISTICS: **COROCARB–NISE** is a tubular electrode filled with fused tungsten carbide and a special nickel alloy for manual welding. This alloy is specially designed for application where extreme abrasion in combination with corrosion is encountered. **COROCARB–NISE** can be overlayed on steel castings, nickel based and stainless steel alloys. The alloy combination of **COROCARB–NISE** is specially designed for items that are exposed to corrosive media and excessive wear conditions. The matrix is highly resistant to acids, lye's and other corrosive media.

APPLICATIONS: Repairing and hardfacing ferritic and austenitic steels (steel castings), stabilizer blades, conveyor screws, milling plates, deep drilling tools, mixer blades.

RECOMMENDED WELDING DIRECTIONS: The alloy has a low melting point of between 950 – 1100°C (1742-2012°F) and characteristically flows extremely well and produces a smooth and clean surface. Note: **COROCARB–NISE** should be welded on the lowest possible AMP setting to avoid carbide damage and achieve maximum wear resistance.

HARDNESS OF WELD METAL:

FTC:	approx.	2360 $HV_{0,4}$
Ni-Matrix:	approx.	480 – 520 $HV_{0,1}$

SIZES AVAILABLE :					
Type	**ø mm**	**Ø inch**	**length of rod**	**Amps**	**Voltage**
4005	4,0 mm	5/32	350 mm	100 A	= + / ~
5005	5,0 mm	3/16	350 mm	120 A	= + / ~
6005	6,0 mm	1/4	350 mm	160 A	= + / ~

Patents:

Germany: No. 40 08 091.9-41
Great Britain: No. 2.232.108
USA: No. 5.004.886

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