

## 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<sub>0,4</sub>

Ni-Matrix: approx.  $480 - 520 \text{ HV}_{0,1}$ 

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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Corodur Fülldraht GmbH may change the characteristics of the wire without notice. Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. We recommend the applier to check our products for their special application autonomously.