COROCARB–NISE-PLUS

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

GENERAL CHARACTERISTICS: **COROCARB–NISE-PLUS** is a tubular electrode filled with spherical fused tungsten carbide (**SFTC**) and a special nickel matrix for manual welding. This alloy is specially designed for application where extreme abrasion in combination with corrosion is encountered.
COROCARB–NISE-PLUS can be overlayed on steel castings, nickel based and stainless steel alloys. The alloy combination of **COROCARB–NISE-PLUS** 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.
Also machine parts in the chemical and food industry**.**

RECOMMENDED WELDING DIRECTIONS: The alloy has a low melting point of between 950 – 1100°C (1.742-2.012°F) and characteristically flows extremely well and produces a smooth and clean surface.
Note: **COROCARB–NISE-PLUS** should be welded on the lowest possible AMP setting to avoid carbide damage and achieve maximum wear resistance.

ANALYSIS:

Ni-Matrix:	approx. 35 – 40%
SFTC:	approx. 60 – 65%

HARDNESS OF WELD METAL:

SFTC:	> 3000 HV
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:

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