

## CORODUR® NiCrMo22

CORODUR® NiCrMo 22 is a flux cored wire which is suitable for medium alloyed steels and high strength steels. This alloy can also be used as a buffer and build-up layer (multiple pass). When NiCrMo 22 is used as buffer and build-up layer for rolls and parts followed by a

hard surfacing alloys, the preheat and interpass temperature should be chosen depending of the C-contents of the base material). The weld deposit is highly crack resistant and is highly resistant to impact and pressure wear.



Build-up layers for carbon steels, buffer layers for continuous casting rolls and Cement Rolls.

### TYPICAL ALL WELD METAL ANALYSIS (%)

Base = Fe

C	Si	Mn	Cr	Ni	Mo
0,06	0,6	1,6	0,4	2,2	0,5

Hardness HB	280-320
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### PARAMETER

Diameter	Voltage	Amps
1,2	20-24	150-200
1,6	22-26	180-240
2,0	25-27	220-260
2,4	25-27	260-300
2,8	26-28	280-340

Other Dimensions on demand

### FORMS OF DELIVERY

Unit	Weight
Coil BS 300	15 kg
Coil B 450	25 kg
Drums	300 kg

G = Gas shielded, OA = Open Arc, SA = Submerged Arc