CEWELD DUR R (Ni)

certilas® THE FILLER METAL SPECIALIST

TYPE	Flexible Nickel based cord filled with tungsten carbides for hardfacing.
APPLICATIONS	Dur R (Ni) offers the highest available wear resistance of all hardfacing alloys in most applications. The deposit offers excellent corrosion resistance combined with tungsten carbides for long life span in extreme applications.
PROPRIÉTÉS	Dur R (Ni) is an extruded oxy-acetylene rod, a newly designed hard-surfacing product consisting of spherical cast tungsten carbide and a Ni-based alloy. Crushed cast carbide will guaranty a long life. Furthermore the Ni-based alloy provides an excellent corrosion resistance Dur R (Ni) has excellent flow and wetting characteristics at low working temperature of around 1050 °C and the deposition rate is 20-30% higher than with comparable tube metal. It is easy to use and inexperienced welders will have no difficulties to produce smooth deposits without cracks. Multi-layer deposits are possible and worn parts can be rebuild without removing the old material. The surface should be free from fats, oil, rust and other foreign matters. Use a larger tip than is generally recommended for same diameter mild steel. Use slight excess acetylene feather. The deposit is not mashinable or forgeable. Only grinding with diamond tools is possible.Dur R (Ni) is available as a 500 mm flexible rod or endless on coils.
CLASSIFICATION	EN ISO 14700: T Ni20
CONVIENT POUR	Scratchers, Mixers, Deep drilling, Bentonit mixers, Cement mixers, Stabilisers, Impellers, Augers etc.
AGRÉMENTS	
POSITIONS DE SOUDAGE	

ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)

WSC
65

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded				45 HRc
As Welded				3000 HV

ETUVAGE	Not required
HARDNESS	Ni-matrix: ± 480-520 HV, WSC (carbides) ± 2350 HV
GAS ACC. EN ISO 14175	R1