

Classifications

DIN 8555	EN 14700
MF 22-GF-45-G	T Ni 20

Characteristics

Hardfacing cored wire containing about 45% special tungsten carbide particles incorporated into a NiB matrix. Thanks to the high degree of preservation of the tungsten carbides in the deposit, this wire offers an outstanding resistance to abrasive wear, even in corrosive environments.

Microstructure:	Tungsten carbides in an austenitic matrix
Machinability:	Grinding only
Oxy-acetylene cutting:	Not possible
Deposit thickness:	6 mm in 2 layers maximum
Shielding gas:	Argon 98% + oxygen 2%

Field of use

Wheel excavator bucket teeth, brick and clay mill augers, wood chipper spouts, bed knives in the paper industry, crusher rollers and dredging wear parts.

Typical all-weld metal analysis in %

C	Mn	Si	Ni	W	B	Fe
2.8	0.1	0.1	balance	42.0	0.7	1.1

Typical mechanical properties

Hardness as welded: 44 HRC

Form of delivery and recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-flow [l/min]
1.6 mm	170 – 220	19 – 23	20 max.	12 - 15