

CEWELD Powder

NiCrBSi WC2

TYPE Nickel based metal powder with high tungsten carbide content

APPLICATIONS CEWELD® Powder NiCrBSi WC2 is a spray powder for overlay spray and fuse and Laser or PTA welding on wear parts that need to outlast new parts where high temperatures combined with corrosion and wear resistance is required.

- Main applications in the field:
 Stabilizers and hard band tools
 Decanter screws
 Debarking knives
 Agitator blades
 Bucket teeth and covers
 Universal fan blades and slag mills
 Agricultural scraper bars

PROPERTIES CEWELD® Powder NiCrBSi is a self fluxing Tungsten alloy with excellent corrosion and wear resistance suitable for working temperatures Up to 650°C. The coatings are dense and practically oxide free. The low friction properties makes the alloy excellently suitable for metal to metal wear. Machinable by grinding.

- Hardness:
 Matrix: 40-60 HRC
 Carbid: 2000-3000 HV01
Standard particle size: 150/52 µm
also possible: 106/20 µm, 106/38 µm, 106/45 µm, 125/38 µm, 125/45 µm, 150/45 µm, 150/53 µm, 150/63 µm, 180/53 µm, 180/63 µm, 210/63 µm, 250/45 µm, 63/20 µm, 75/20 µm

CLASSIFICATION EN ISO 14232-1 WC-NiCr 60/30/3

SUITABLE FOR For coating the following base materials:
 Structural steel, stainless steel, nickel alloys, heat-treatable steels, if preheated to 300 °C (570 °F) to prevent extensive cracking in the coating.

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

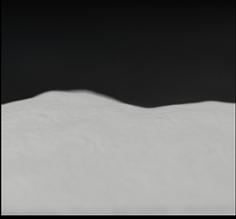
C	Si	Cr	Ni	Fe	B	WC
2.5	1.8	3	Rem.	0.6	1.2	60

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded				50 HRc

REDRYING Not required

GAS ACC. EN ISO 14175 None



CEWELD Powder NiCrBSi WC2

POWDER NICRBSI WC2 (-
125/25 MM)MM

Packaging	KG/unit	EanCode
Can	3,5	8720663410542