

Supershield CrCB

Cr-Carbide Type

Conformances

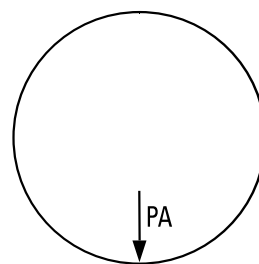
Applications

- Cement roll mill, bucket teeth and lips, crusher and coke hammers, wear plate

Features

- Open arc type hardfacing wire
- Cr-Carbide + B-Carbide type

Welding Position



Current

DC +

Welding Process

Open Arc

Diameter / Packaging

Diameter mm (in)	Coil			Pac	
	25kg (55lbs)	150kg (330lbs)	250kg (551lbs)		
2.4 (3/32)	✓	✓	✓		
3.2 (1/8)	✓	✓	✓		

Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	P	S	Cr	Ti	B
As welded with 2.4/3.2mm wires	4.5	0.6	1.4	0.011	0.002	26.0	0.1	0.3

Typical Mechanical Properties of All-Weld Metal

		Rockwell Hardness(HRc)		
		1 Layer	2 Layers	4 Layers
On Mild Steel	2.4mm	-	-	60-63
	3.2mm	-	-	62-65

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
3.2mm (1/8in), DC+					
Open Arc	25 (1)	1.5 (60)	360	29	5.4 (11.9)
		1.8 (71)	400	30	6.6 (14.5)
		1.9 (75)	430	32	7.5 (16.5)

SMAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX