

Supershield CrCMo

Cr-Carbide Type

Conformances

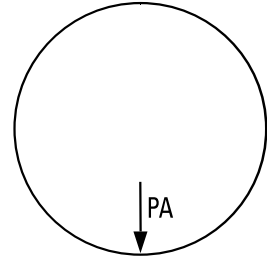
Applications

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

Features

- Open arc type hardfacing wire
- Cr-Carbide + Mo-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)	✓	✓	✓
2.8 (7/64)	✓	✓	✓

Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	P	S	Cr	Mo
As welded with 2.4/2.8mm wires	5.0	1.0	0.4	0.011	0.003	27.0	1.2

Typical Mechanical Properties of All-Weld Metal

		Rockwell Hardness(HRc)		
		1 Layer	2 Layers	4 Layers
On Mild Steel	2.4mm	-	-	59-63
	2.8mm	-	-	59-63

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)
2.8mm (7/64in), DC+					
Open Arc	25 (1)	2.9 (117)	330	28	5.2 (11.4)
		3.7 (146)	380	29	6.4 (14.1)
		4.4 (174)	430	30	7.3 (16.0)

SMW

SAW

GMW

GTW

FCW

Non-FERROUS

APPENDIX