

Supershield CrCW

Cr-Carbide Type

Conformances

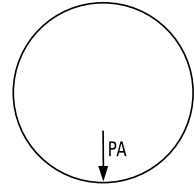
Applications

- Wear plate, conveyor screws, bucket teeth

Features

- Open arc type hardfacing wire
- Cr-Carbide type

Welding Position



Current

DC +

Welding Process

Open Arc

Diameter / Packaging

Diameter mm (in)	Spool		Coil	Pac		
	12.5kg (27.6lbs)	15kg (33lbs)	25kg (55lbs)	150kg (330lbs)	250kg (551lbs)	350kg (771lbs)
1.2 (0.045)		✓				
1.6 (1/16)		✓				
2.4 (3/32)			✓	✓	✓	
2.8 (7/64)			✓	✓	✓	
3.2 (1/8)						

SMW

SAW

GMW

GTAW

FCAW

Non-FERROUS

APPENDIX

Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	P	S	Cr
As welded with 1.2mm wires	4.2	0.5	0.6	0.011	0.006	22.0
As welded with 1.6mm wires	4.5	0.5	0.7	0.011	0.006	25.0
As welded with 2.4/2.8mm wires	5.0	1.0	1.8	0.012	0.008	25.0

Typical Mechanical Properties of All-Weld Metal

		Rockwell Hardness(HRc)		
		1 Layer	2 Layers	4 Layers
On Mild Steel	1.2/1.6mm	40-44	46-49	53-56
	2.4/2.8mm	48-52	52-57	57-62

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)
1.6mm (1/16 in) DC+					
Open Arc	25 (1)	5.0 (196)	250	28	3.4 (7.4)
		7.5 (295)	300	29	5.2 (11.4)
		11.5 (452)	350	32	7.4 (16.3)
2.8mm (7/64in), DC+					
Open Arc	25 (1)	2.9 (117)	330	28	5.2 (11.4)
		3.7 (146)	380	29	6.3 (13.9)
		4.4 (174)	430	30	7.2 (15.8)