

Field of use

The nickel base metallic powder PLASweld™ NiBas068HH is designed for cladding similar corrosion and temperature resistant nickel base alloys and for surfacing mild steels. PLASweld™ NiBas068HH can be used in the chemical and petrochemical industries as well as for repair purposes (e.g. valve cladding as buffer layer).

Typical analysis in %

C	Si	Mn	Cr	Nb	Fe	Ni
0.10	0.5	3.0	15	2.5	1.0	balance

Characteristics

PLASweld™ NiBas068HH is characterized in high hot crack resistance with high corrosion resistance in various atmospheres. The welding deposit does not tend to embrittlement.

Hardness weld metal : 180 HV

Welding instruction

Preheating and interpass temperature should be adjusted to the base metal. To obtain the best weld metal properties, it is necessary to optimize the main and pilot arc, plasma gas, welding speed and distance, weave width and powder flow.

Preheating and interpass temperature (if necessary) have to be adjusted to the base metal to minimize cracking. To obtain the desired metal properties, it is necessary to optimize laser output, flow rate control of powder and powder gas, type and quantity of shielding gases, welding strategy, welding speed and weld distance.

Availability

-150 + 50 µm in 5 kg powder containers

-200 + 63 µm in 5 kg powder containers

Further packaging size and grain size ranges on demand.