

## Classifications

DIN 8555	EN 14700
G/WSG 21-UM-55-CG	C Ni 20

## Characteristics and field of use

WEARtig XD NiW60 can be welded by oxy-acetylene or TIG process. The rod is based on a NiCrBSi matrix containing tungsten carbides. These carbides have two different grain sizes and build a compact wear-resistant deposit. The matrix melts at 1050 °C, i.e. below the melting range of steels.

WEARtig XD NiW60 is particularly suitable for claddings on machine parts subject to extreme friction wear by hard, abrasive materials. This alloy is used in brickyards, the clay industry, cement factories, mining and offshore as well as for the production of equipment and machines for the above-mentioned industries.

Only suitable for slight to medium impact stress. The weld deposit is corrosion-resistant.

### Hardness:

Carbides: approx. 2500 HV

Matrix: approx. 55 HRC

## Typical analysis in %

W <sub>2</sub> C	NiCrBSi-Matrix
60	40

## Welding instructions

The weld area must be metallic clean. Preheating to 300 – 500 °C depending on the size of the workpiece. Keep welding torch flat to the work piece and slightly melt the surface. Avoid overheating.

Availability	Current type	Shielding gas
Ø 6.0 x 450 mm length	DC (-)	I 1
Ø 5.0 mm spooled wire	DC (-)	I 1
Ø 6.0 mm spooled wire	DC (-)	I 1