

Classifications

EN 14700	DIN 8555
E Z Ni2	E23-UM-200-CKTZ

Characteristics and typical fields of application

WEARstick Tool NiCrMo+ is particularly suited for wear resisting cladding on working surfaces of hot working tools subject to thermal load, such as forging jaws, forging dies, forging saddles, hot piercing plugs, hot cutting tools, hot trimming tools, roll mandrils, hot moulding plugs.

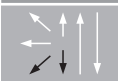
WEARstick Tool NiCrMo+ has excellent welding properties, a regular and finely rippled bead appearance due to spray arc. Very easy slag removal. The weld deposit is highly corrosion resistant, scale resistant and workhardening. Machinable with cutting tools.

Hardness of the pure weld deposit : approx. 220 HB
after workhardening: approx. 450 HB

Typical analysis

	C	Si	Mn	Cr	Ni	Mo	W	Co	Fe
wt.-%	0.04	0.3	0.9	16.0	bal.	17.0	5.0	1.5	5.0

Operating data

	Polarity	DC + / AC	Dimension mm	Current A
	Redrying	300°C / 2 h	2.5 × 350	80 – 100
			3.2 × 350	100 – 120
			4.0 × 350	130 – 160
			5.0 × 450	180 – 220

Welding instructions

Clean welding area, preheat tools to 350 – 400 °C and maintain this temperature during the whole welding process. Slow cooling in an oven. Hold stick electrode vertically and with a short arc. Select lowest possible amperage, in order to reduce dilution with the base metal. Cracks in the tool have to be gouged out completely and welded with UTP 7015 or Thermanit Micro 82. Final layers have to be welded with WEARstick Tool NiCrMo+.

Approvals

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