WEARcore XD 67-O

open arc metal cored wire

Classifications	
EN 14700	DIN 8555
T Z Fe16	MF 10-GF-70-GT

Characteristics

Special Chromium-Niobium-Boron alloy designed to give extreme resistance to high stress grinding abrasion without impact. The typical hardness is achieved in the first layer. The deposits will show stress relief cracks.

Microstructure: Borides and Niobium carbides in eutectic matrix

Machinability: Grinding only

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: 6 to 8 mm in 2 layers maximum

Shielding gas: Argon 98 % + Oxygen 2 % (if not used as open-arc)

Field of use

Extrusion screws, screw conveyors, mixers, scrapers, subsoiler teeth, agriculture and earth moving machinery wear parts, etc.

Typical analysis in %

C	Mn	Si	Cr	Nb	B	Fe
2.7	1.8	1.1	14.8	4.6	1.9	balance

Typical mechanical properties

Hardness as welded: 67 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.2	110 – 180	20 – 31	15 – 25
1.6	150 – 250	20 – 31	15 – 35
2.4	200 – 300	20 – 31	15 – 35