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| Technical data sheet 060318 | <p style="text-align: center;">Tubular welding electrode</p> <h1 style="text-align: center;">HARDFACE CNV-TE</h1> |  |
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CLASSIFICATION

EN 14700: TFe16 - C6Cr20Nb6Mo5W2V1-65

DESCRIPTION

- High chromium cast iron with extra alloying additions for hardfacing of components subject to extremely severe abrasive wear at high temperatures
- The deposit contains a high proportion of hard primary and secondary chromium and complex carbides in a tough austenitic-martensitic matrix
- The alloy maintains its abrasive resistance up to 650°C

APPLICATIONS

- Typical applications include boiler components, high temperature components of process industry such as sinter plant or blast furnace components etc.

TYPICAL ALL-WELD METAL ANALYSIS

| C | Mn | Si | Cr | Mo | Nb | V | W | Fe |
|-----|-----|-----|------|-----|-----|-----|-----|-----|
| 6.0 | 1.0 | 0.9 | 20.0 | 5.0 | 6.0 | 1.2 | 1.5 | Bal |

Structure: Heat-resistant complex alloy carbides in an austenitic-martensitic matrix.

TYPICAL MECHANICAL PROPERTIES

Typical hardness (3 layers): 65 HRC

CONDITIONS OF USE

| | | | |
|------------------------|-----------|------------|------------|
| Electrode Ø x L (mm) | 6.0 x 450 | 8.00 x 450 | 12.0 x 450 |
| Current (A) | 85 - 135 | 130 - 190 | 200 - 430 |

Polarity: AC or DC

WELDING POSITIONS

Flat, half up and half down

PACKAGING

| Diameter x length [mm] | Quantity | Weight [kg] |
|------------------------|----------|-------------|
| 6.0 x 450 | ~61 | 4 x 5.0 |
| 8.0 x 450 | ~36 | 4 x 5.0 |
| 12.0 x 450 | ~17 | 4 x 5.0 |

TYPICAL COVERAGE (APPROX) IN KG PER SQUARE M X 3MM HIGH

| Diameter x length [mm] | Weight [kg] |
|------------------------|-------------|
| 6.0 x 450 | 30 |
| 8.0 x 450 | 30 |
| 12.0 x 450 | 30 |

TIP COLOUR IDENTIFICATION

- White