Supershield CrC

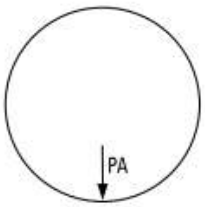
Cr-Carbide Type

Conformances

Applications

- Cement roll mill, bucket teeth and lips, crusher and coke hammers, wear plate

Welding Position



Features

- Open arc type hardfacing wire
- Cr-Carbide type

Current

DC +

Welding Process

Open Arc

Diameter / Packaging

Diameter	Spool		Coil	Pac		
mm (in)	12.5kg (27.6lbs)	15kg (33lbs)	25kg (55lbs)	150kg (330lbs)	250kg (551lbs)	350kg (771lbs)
1.2 (0.045)		√				
1.6 (1/16)		√				
2.4 (3/32)			√	√	√	
2.8 (7/64)			√	√	√	
3.2 (1/8)						

Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	P	S	Cr
As welded with 1.2mm wires	4.1	0.4	1.1	0.011	0.004	22.0
As welded with 1.6mm wires	4.5	0.4	1.2	0.011	0.004	25.0
As welded with 2.4/2.8mm wires	5.2	0.6	1.4	0.013	0.005	28.0

Typical Mechanical Properties of All-Weld Metal

		Rockwell Hardness(HRc)		
		1 Layer	2 Layers	4 Layers
On Mild Steel	1.2/1.6mm	42–46	50–54	54–58
	2.4/2.8mm	50–52	54–57	58–62

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
1.6mm (1/16 in) DC+					
Open Arc	25 (1)	5.0 (196)	250	28	3.4 (7.4)
		7.5 (295)	300	29	5.3 (11.6)
		11.5 (452)	350	32	7.5 (16.6)
2.8mm (7/64in), DC+					
Open Arc	25 (1)	2.9 (117)	330	28	5.2 (11.4)
		3.7 (146)	380	29	6.4 (14.1)
		4.4 (174)	430	30	7.3 (16.0)

Caution	① This product is an open-arc type wire.
Purpose	① Cement roll mill, bucket teeth and lips, crusher and coke hammers, wear plate
Attribute	① Open arc type hardfacing wire ② Cr-Carbide type