PRIME WELD

PRIME H33Nb-0

Flux Cored Wire
For Hard Surfacing

Classifications:
EN ISO 14700 : T Fe 15

Welding Positions: 

Characteristics and Applications:

PRIME H33Nb-0 is a self-shielded chrome carbide flux cored wire depositing extremely hard abrasion resistant Chromium-Niobium carbades in an austenitic matrix. It is ideal for hard surfacing applications when resistance to extreme abrasion, heavy impact, heat and corrosion resistance up to 450°C (842°F) are required. Typical applications include palm oil mill screw and high pressure kerned worms screw, vertical crushers, oil expeller screws, mineral conveying equipment, bucket wheel excavator, shovel bucket teeth and etc.

Chemical Properties of Weld Metal (Wt%)

C	Mn	Si	Cr	Nb	S	P
4.90	0.85	0.70	21.80	7	0.011	0.013

Deposit Rating Scale

ABRASION										
IMPACTS										
HEAT										
CORROSION										
	1	2	3	4	5	6	7	8	9	10

- Single layer deposit hardness may vary depending on the base material metal type and degree of dilution.

Hardness (as-welded) : 60 - 65 HRC
Deposit thickness : 2 passes maximum

Sizes Available and Recommended Currents (DC-)

Diameter (mm)	1.6	2.0
Current (A)	180-300	200-340
Voltage (V)	22-28	24-32
Spool (Kg)	15	15