DURMAT® NICRW

Flux-Cored Wire DIN EN 14700: T Ni20
(DIN 8555: MF21-55-CGZ)

General characteristics:

DURMAT NICRW is a flux-cored wire with approx. 50% FTC, similar DURMAT NIFD, but containing higher Chrome content. Good corrosion protection against chloride media. DURMAT NICRW was developed to protect surfaces against extreme abrasive wear in combination with corrosion attacks. The deposit alloy consists of approx. 50% FTC and 40% NiCrBSi-matrix. The alloy has a low melting range of between 900 – 1050°C (1,652 – 1,922°F) and feature self fluxing characteristic producing a smooth and clean surface. The matrix is highly resistant to acids, bases, lye's and other corrosive media.

Chemical Composition (in wt-%):

FTC	Cr	B	Ni	Si	C
50	10-12	1.7-2.0	Balance	4-5	0.4

Physical characteristics:

Hardness:

FTC:	>2200 $HV_{0.1}$
Matrix:	490-540 $HV_{0.1}$

Welding recommendation:

Ø mm	Ø inch	Coil size DIN EN 759	Amps	Voltage
1.6	1/16	B 300 cages ca. 15 kg	160 - 180 A	18 - 20 V
2.4	3/32	B 435 cages ca. 25 kg	200 - 230 A	21 - 23 V
2.8	7/64	B 435 cages ca. 25 kg	220 - 260 A	21 - 23 V

The area to be hard-faced should be free of rust, scale, oil and other dirt. Be sure that the base material is not overheated and choose amps and volts as low as possible to avoid melting the tungsten carbide.

Please observe all appropriate safety regulations in force. The technical informations given in this data sheet reflects the present state of knowledge. They do not form part of any sales contract as guaranteed properties of the delivered materials. Our delivery and sales conditions apply to all contracts included.