

# DURMAT<sup>®</sup> NIA-PLUS

**Stick Electrode DIN EN 14700: T Ni20  
(DIN 8555: E21-GF-55-CG)**

## General characteristics:

DURMAT NIA-PLUS is a cold rolled, formed, and closed seam nickel tube filled with spherical fused tungsten carbide (SFTC) and Cr, B and Si for oxyacetylene application. The deposited alloy consists of approximately 65% SFTC and 35% Ni-Cr-B-Si-matrix. DURMAT NIA-PLUS wets easily and has excellent flow producing a smooth, clean surface. DURMAT-NIA-PLUS feature self fluxing characteristic producing a smooth, clean surface. The overlay is extremely wear resistance and anti corrosive to acids, bases, lye and other corrosive media.

## Application:

Hard facing on ferritic and austenitic steels (steel casings), overlaying mixer blades, conveyors and screws in chemical, dye and food industry. Recommended for hard facing rock bits and stabilizers in the petroleum industry.

## Physical characteristics:

Hardness: SFTC: > 3000 HV<sub>0.1</sub>  
NiCrBSi-Matrix: approx. 450 - 520 HV<sub>0.1</sub>

## Sales units:

Type	Ø mm	Ø inch	grain size mm	US mesh size	Color code
4005	4.0	5/32	0.25 – 0.84	20 – 60	white
5005	5.0	3/16	0.25 – 0.84	20 – 60	white
6005	6.0	1/4	0.25 – 0.84	20 – 60	white

Standard tube metal length: 700mm (28")

## Welding recommendation:

The surface to be hard faced should be clean and free of rust, scale or grease and other contamination, preferably by grinding or grit blasting. Deposits should be made using a gas flame with a neutral to slight acetylene balance.