

# Supershield CrCNb5

Cr-Carbide+Nb-Carbide Type

## Conformances

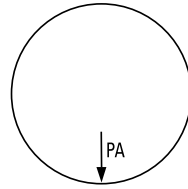
## Applications

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

## Features

- Open arc type hardfacing wire
- Cr-Carbide + Nb-Carbide type

## Welding Position



## Current

DC +

## Welding Process

Open Arc

## Diameter / Packaging

Diameter	Coil	Pac	
mm (in)	25kg (55lbs)	150kg (330lbs)	250kg (551lbs)
2.8 (7/64)	√	√	√

## Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	P	S	Cr	Nb
As welded with 2.4mm wires	5.0	1.0	0.5	0.010	0.006	22.0	4.8

## Typical Mechanical Properties of All-Weld Metal

	Rockwell Hardness(HRc)		
	1 Layer	2 Layers	4 Layers
On Mild Steel (2.4mm)	-	-	60-64

## 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)
2.4mm (3/32in), DC+					
Open Arc	25 (1)	2.2 (85)	300	28	3.8 (8.3)
		2.7 (105)	340	29	5.5 (12.1)
		3.1 (124)	380	30	7.1 (15.6)