

PRODUCT DATA SHEET

Corewear 68NM-G

Corewear 68NM-G is a gas assisted flux cored wire. It has a stable arc and low slag levels. Its deposit efficiency is around 93%. The weld metal contains some carbide forming elements such as Cr, Nb and Mo. It offers excellent resistance to severe abrasion.

Applications

Corewear 68NM-G is suitable for hardfacing hopper liners for steel mills, roll crushers for cement, roll mills for crushing coal and table liners. For the hardfacing of high carbon or low alloy steels, a buffer layer of austenitic stainless steel should be applied first. The number of layers should be limited to avoid cracking. If several layers are required, the rib or waffle pattern should be used.

Classifications

DIN	8555	MF10-GF-70-G (nearest)
-----	------	------------------------

Typical Chemical Analysis (All weld metal)

% Carbon	6,5	% Molybdenum	1,8
% Manganese	0,3	% Niobium	2,9
% Silicon	2,2		
% Chromium	23,2		

Typical Hardness

HRC	67 (5th layer)
-----	----------------

Welding Data

(DC+)

Diameter (mm)	Current		Gas Flow (CO ₂ l/min)
	Amps (A)	Volts (V)	
1,6	200 - 350	25 - 34	15 - 25

Packing Data

Diameter (mm)	Spool Mass (kg)	Spool Type	Item Number
1,6	20,0	Wire Basket	W077403

Recommended shielding gas: 100% CO₂

The information contained or otherwise referenced herein is presented only as typical without guarantee or warranty, and Afrox expressly disclaims any liability incurred from any reliance therein. No data is to be construed as recommended for any welding condition or technique not controlled by Afrox.

For more information contact the Afrox Customer Service Centre Tel: 0860 02 02 02
E-mail: customer.service@afrox.linde.com Website: www.afrox.com

