

# **Supershield CrCNb5**

CHROMIUM CARBIDE + NIOBIUM CARBIDE TYPE OPEN ARC WIRE



# Supershield CrCNb5

## ❖ Specification

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## ❖ Description & Applications

Supershield CrCNb5 is an open arc wire on a Cr–Carbide+Nb–Carbide basis for extreme hard deposits on parts subject to severe abrasion.

(Wear Plate, Screen in the coal industry, Bucket teeth etc.)

## ❖ Welding Process

Open Arc Type

## ❖ Current Type

DC+



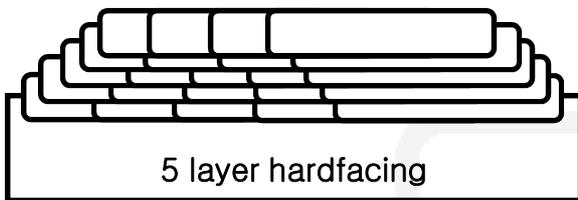
## ❖ Packing

<b>Supershield CrCNb5</b>	<b>Dia.</b>	2.4mm(3/32in)
	<b>Coil</b>	25kg(55lbs)
	<b>Pailpack</b>	150kg(330lbs), 250kg(551lbs)



## Mechanical Properties & Chemical Composition of All Weld Metal

### ❖ Welding Conditions



<b>Diameter</b>	: 2.4mm(3/32in)
<b>Welding Type</b>	: Open Arc
<b>Amp./ Volt.</b>	: 350/30
<b>Stick-Out</b>	: 25~30mm(0.98~1.18in)
<b>Pre-Heat</b>	: 150~250℃ (302~482°F)
<b>Interpass Temp.</b>	: 200~300℃ (392~572°F)
<b>Total layers</b>	: ≥4 layer

### ❖ Chemical Analysis of All weld metal(wt%)

Consumable	C	Si	Mn	Cr	Nb
Supershield CrCNb5	5.0	1.1	0.5	22.0	4.8

### ❖ Hardness test of All weld metal(HRc)

Consumable	Hardness(HRc)					Avg.
Supershield CrCNb5	62	63	63	65	67	64



## Test Results

### ❖ BEAD APPEARANCE

<b>Consumable</b>	Supershield CrCNb5
<b>Amp.(A)</b>	330~350
<b>Volt.(V)</b>	29~30
<b>Carrige Speed</b>	40~60cm/min(15.7~23.6in/min)
<b>Welding Position</b>	Flat(1G)



This information is provided solely for the purpose of confirming product conformance with applicable standards. The serviceability of a product or structure utilizing this type of information is and must be the sole responsibility of the builder/user. Many variables beyond the control of HYUNDAI WELDING CO., LTD. affect the results obtained in applying this type of information. These variables include, but are not limited to, welding procedure, shielding gas, plate chemistry and temperature, weldment design, fabrication methods and service requirements.