AI-1579Nb

Specifications

DIN 8555 : DIN EN 14700

MF 10-70-GZ T Fe 16-70-GZ

Description and Applications

AI-1579Nb is a C-, Cr-, V-, Nb- B flux-cored wire designed for parts that are exposed to extreme mineral wear with light impact stress. The weld deposit has a very high scratch hardness. Typical applications are sinter plants, lignite mining bucket wheels, drag-line buckets and chains, gravel mining, sand dredging, and ground engaging tools in the agricultural sector.

Applications

Mining, Cement Clinker, Sinter (the hardness can be maintained without any significant degradation up to 650°C). Cement pumps, slurry chutes , agricultural tines, bucket sides, dredges, tooth adapters

Typical Weldmetal Analysis

C	Si	Cr	Fe	Nb	V	Other
5	<1.5	21	Bal	>6	<6	1.5

Mechanical Properties of Weldmetal

	As Welded
Hardness	64-68HRC

Maximum hardness achieved in 2nd and 3rd layers

Welding Parameters

Diameter (mm)	Amps	Voltage
1.2	150-180	20-28
1.6	160-280	20-26
2.0	240-280	22-26
2.4	280-340	23-27
2.8	320-400	25-28

Available in 15kg spools or 300kg pay off packs

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. Parts to be hardfaced should be pre-heated to a temperature of 450°C. Taking care to maintain this temperature as a minimum during welding and cooling the parts under a blanket and if practical in an oven. Maximum 2-3 layers (~10mm).

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Disclaimer

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