



PRODUCT DATA SHEET



ArcoCrush Ni 60 – GS (Gas- shielded)

ArcoCrush™ is a family of alloys tailored to meet the aggressive applications of Australian Industries wear management

CLASSIFICATIONS	AS/NZS 2576-2005, 3660-B5 EN 14700 T Fe20 50 CGRZ
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ArcoCrush Ni 60 is a tubular cored hardfacing wire used for armouring & cladding as resistance to extreme abrasion in corrosive service applications up to 650°C. This alloy contains up to 60% Spherical Fused Tungsten Carbide (SFTC) within a Chromium Nickel matrix (CrNi).

The fine Tungsten carbide particles within the wire core remain solid during the welding process therefore requiring a minimal level of heat input to preserve particle integrity, a lower amperage setting also ensures the particles are evenly distributed throughout the weld deposit. Overheating is presented by a dark surface of weldment. Wire size diameter limit WC volume due to wire fill ratio, smaller wires typically deliver 45% for 1.6mm.

The weld deposit is non machinable.

Applications

Oil & Gas downhole tools including stabilisers, BHA tools, Drilling Collars, Hole openers, open hole drilling tools, armouring against corrosion / abrasion, sizing screens, crushing components, earthmoving equipment, (bucket lips, rippers), brick industry components, pump impellers, augers, slurry pipework cladding, wearplate cladding.

Post weld Relief checking is normal. Best limited to two (2) layers maximum.

Gas shielding is required with Argon 100% or Argon/Co² 1-25%, torch electrode positive polarity (DCEP)

Typical All- weld Metal Composition (Weight%)

C	WC	Cr	other	Ni
1.2	45- 60	10	1.5-2.5	Balance

Typical All- weld Metal Hardness range

60 HRc (2 layer)	Tungsten Carbide Particles
627 HB	2350 HV

PACKAGING

15kg, 25kg coils

Wire diameter Sizes

1.6mm,2.4mm 2.8mm