

# CARBO DURIT CN 60

<b>Standards</b>	DIN 8555	E21-GP
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**Characteristics** CARBO DURIT CN 60 is a nickel based alloy welding rod including crushed sintered tungsten carbide fragments for the oxyacetylene welding process.

**Operating temperature** ---

**Typical applications** It is to expect on-armor-platings of tools and machine parts in the mining, road construction, well digging, special civil engineering, depression drilling technology, where strongest abrasion by minerals may occur.

**Recommendations for best welding results** To get a good result the welding areas should be properly cleaned of rust, grease, tinder and similar pollutions. Apply a thin layer of NiCrBSi before hardfacing. Use a neutral or slightly carburizing flame with enough heat to be able to move the carbide chips around locating them properly before the nickel alloy freezes. The selection of the grain size and the rod diameter depend on the application and the size of the tool to be hard faced. Lower particle sizes are recommended when the wear from abrasion is dominant, bigger sizes for fitting a tool for stronger cutting strength.

<b>Mechanical properties of all-weld metal ( typical values )</b>	<b>Hardness of sintered tungsten carbide HV</b>
	> 2300

<b>Weld metal analysis (typical, wt. %)</b>	<b>Ni-Base Matrix</b>	<b>Sintered tungsten carbide</b>
	ca. 40	ca. 60

Rod length	350mm	450mm	450mm	450mm	Colour	kg/packet
Rod weight	250g	500g	750g	1000g		
Grain sizes mm	1,6-3,2	1,6-3,2	1,6-3,2	1,6-3,2	Blue	25
	3,2-4,8	3,2-4,8	3,2-4,8	3,2-4,8	Green	25
	4,8-6,4	4,8-6,4	4,8-6,4	4,8-6,4	Yellow	25
	6,4-8,0	6,4-8,0	6,4-8,0	6,4-8,0	Red	25
	8,0-9,5	8,0-9,5	8,0-9,5	8,0-9,5	White	25
	9,5-11,0	9,5-11,0	9,5-11,0	9,5-11,0	black	25

Other grain sizes are possible on request

Rev. 000