SelectWear NiBWC

Hardsurfacing / Gas Shielded / Flux Cored

PRODUCT DATA SHEET

FEATURES

- Tungsten carbide particles in a nickel-silicon-boron matrix
- The nickel-silicon-boron matrix provides a high toughness matrix system for the tungsten carbide particles
- Provides excellent abrasion resistance along with good corrosion resistance and moderate impact resistance
- Can be welded at very low heat inputs, preserving the integrety of the tungsten carbide particles
- Hot wear hardness up to 900f

DIAMETERS [in [mm]]

1/16 (1.6)

POSITIONS

SHIELDING GAS

75% Ar/25% CO2
Flow Rate: 40 - 50 CFH

POLARITY

Direct Current Electrode Positive (DCEP)

HARDNESS

Matrix: 40-45 HRC, Tungsten Carbide: >70HRC HRC

TYPICAL WELD DEPOSIT CHEMISTRY [WT%]

Shielding Gas	B	C	Ni	Si	W
75%Ar / 25%CO2	1.0	2.4-3	Bal.	2.2	38-45

RECOMMENDED WELDING PARAMETERS **

Diameter in (mm)	Shielding Gas	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
1/16 (1.6 mm)	75% Ar/25% CO2	Flat & Horizontal	120 (3.0)	120	18	3/4 - 1 (19 - 25)

** WFS = Wire Feed Speed, CTWD = Contact Tip To Work Distance*
***The parameters listed are recommended starting points of operation and the ranges for amperage, wfs, and voltage could be extended based on fitness for application. For products with "all-position" capability, as determined and listed in classification, the position recommendation can be determined based on operator skill and material thickness and isn't limited to the listing.*

PACKAGING [lbs [kgs]]

33 (15) Spools, 60 (27.2) Coils, 500 (226.8) Round Drum, 800 (362.9) Hex Drum, 900 (408.2) Hex Drum

**Some packaging options may not be available depending on diameter and product. Special package options may be available upon request.*

STORAGE AND HANDLING

All products should be stored in original packaging, in dry conditions and handled with care. For more information refer to our website.

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