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Postalloy® DuraHard™ 2828NCTi-FCO is a non-cracking flux-cored, open-arc hardfacing wire that deposits a martensitic alloy with a high volume of finely dispersed Titanium Carbides (TiC). It has excellent abrasion resistance under low and high stress conditions and retains hardness at high temperatures. Crack-free deposits are possible with proper procedures. Use on carbon and low alloy steels.

- Excellent welding characteristics..
- Multiple layers maintain their hardness and abrasion resistance..
- Produces full slag coverage that does not require removal between passes. Slag is easily removed with a chipping hammer.
- Deposits are crack-free even after multiple layers.

Especificaciones

Tipo de producto

Wire: Flux-cored, open-arc

****RCT™ Reactive Core Technology** improves weldability and optimizes wear properties. Learn more.

Propiedades de la soldadura

Average Hardness: 57-60Rc

Good Hot-hardness: up to 1100° F (593°C)

Maximum overlay : Unlimited layers with proper procedures, including preheat and interpass temperatures

Non-Machinable: Must be ground

Cannot be flame-cut

Applications

Cement rolls
Hardbanding drill pipes
Hammers
Bucket pins
Shredder & Fibrizer hammers

Bucket teeth and lips
Tillage implements
Augers
Asphalt mixer paddles

Postalloy® DuraHard™ 2828NCTi-FCO Configuración de soldadura

Current: Use DC Electrode Positive

Diameter	Amps	Volts	Stick Out
3/32" (2.4mm)	280-340	26-30	1"-1½"(25-38mm)
1/16" (1.6mm)	210-250	26-29	1"- 1 1/4 " (25-32mm)
7/64" (2.8mm)	325-500	26-30	1"- 1 1/2 " (25-38mm)

Procedimiento de soldadura

Out of position welding is limited to horizontal stringers. Preheats and Inter-pass temperatures should be based on base metal chemistry.

Opciones de embalaje

Diámetro	Empaque estándar
3/32" (2.4mm)	55 lb spool
7/64" (2.8mm)	55 lb spool
1/16" (1.6mm)	25 lb spool

