

CARBOLOY 99

International standards

DIN 8555	E 22-UM-60-CGZ
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Approvals ----

Characteristics CARBOLOY 99 is a very high efficient electrode with about 220% recovery for hardfacings on tools which have to stand the combined wear of corrosion, abrasion, erosion and impact.
The weldability of the CARBOLOY 99 is excellent as well on DC as on AC.
The deposits include a lot of well combined special carbides in a very corrosion resistant Ni-base alloy matrix.

Applications Claddings on pumps and mixers especially in the salt, potash, and chemical industry

Operating temperature ---

Hardness of all-weld metal (typical values)	HRc
	58 - 60

Weld metal analysis (typical, wt. %)	Hard phases	Ni-base Matrix
	65	35

Current = + / ~ 50 V

Welding positions PA, PB, PC, PD, PE, PF

Rebaking 1 h, 300 °C + / - 10 °C (if required)

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2,5 x 350	90 – 110	133	533	37,5	5,0	20,0
3,2 x 350	120 – 140	79	315	63,5	5,0	20,0
4,0 x 350	150 – 200	52	208	96,3	5,0	20,0
5,0 x 450	180 - 220	31	124	193,5	6,0	24,0

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