

CARBOLOY 99

International standards		DIN 85	555	E 22-UM-6	0-CGZ		
Approvals							
Characteristics		CARBOLOY 99 is a very high efficient electrode with about 220% recov- ery for hardfacings on tools which have to stand the combinated 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 combinated special carbides in a very corrosion resistant Ni-base alloy matrix.					
Applications		Claddings on pumps and mixers especially in the salt, potash, and chemi- cal industry					
Operating temperature							
Hardness of all-weld metal (typical values)							
of all-weld me			HRc 8 - 60				
of all-weld me (typical values	5)		8 - 60	s	Ni-ba	se Matrix	
of all-weld me	alysis		-	IS	Ni-ba	se Matrix 35	
of all-weld me (typical values Weld metal ar	alysis	= + / ~	8 - 60 Hard phase 65		Ni-ba		
of all-weld me (typical values Weld metal ar (typical, wt. %) Current	alysis	5 = + / ~ PA, PE	8 - 60 Hard phase 65 50 V	PF			
of all-weld me (typical values Weld metal ar (typical, wt. %) Current Welding posit	alysis	5 = + / ~ PA, PE 1 h, 30	8 - 60 Hard phase 65 50 V 3, PC, PD, PE,	PF C (if requ	ired)		kg / carton
of all-weld me (typical values Weld metal ar (typical, wt. %) Current Welding posit Rebaking	alysis ions	5 = + / ~ PA, PE 1 h, 30 je (A)	8 - 60 Hard phase 65 50 V 3, PC, PD, PE, 00 °C + / - 10 °(PF C (if requ	ired)	35	kg / carton 20,0
of all-weld me (typical values Weld metal ar (typical, wt. %) Current Welding posit Rebaking Dia./Length	;) nalysis tions <u>Amperag</u> 90 – 7 120 – 7	5 = + / ~ PA, PE 1 h, 30 je (A) 110	8 - 60 Hard phase 65 50 V 3, PC, PD, PE, 00 °C + / - 10 °(Pcs./ packet	PF C (if requ Pcs./ carton	ired) kg / 1000	35 kg / packet	

5,0 x 450 Rev. 000

4,0 x 350

150 - 200

180 - 220

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.

208

124

96,3

193,5

5,0

6,0

20,0

24,0

52

31