

NA 1961

Technical data sheet

CLASSIFICATION

EN 14700 T Fe8

DESCRIPTION

- Seamless copper coated tubular wire for semi-automatic gas shielded hardfacing
- The martensitic weld deposit contains finely dispersed hard carbides ensuring an optimal balance between abrasion metal to metal wear and impact resistance
- The wire does not pick up moisture. Wire feeding properties are excellent. Welder appeal is outstanding.

APPLICATIONS

NA 1961 is specially designed for hardfacing new or worn ceramic moulds

TYPICAL ALL-WELD METAL ANALYSIS PROPERTIES

C	Mn	Si	Cr
0.35	0.7	2.5	9.5

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Current type	Hardness – First layer	Hardness – Third layer
DC+	52 – 55 HRc	55 – 60 HRc
DC-	55 – 57 HRc	57 – 62 HRc

SHIELDING GAS

En iso 14175: M12 Ar + 2 – 5% CO₂ with or without helium
M13 Ar + 2 - 3% O₂
M21 Ar + 15 - 25% CO₂

OPERATING CONDITIONS

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out	Gas flow
1.2	DC (-), DC8+ or pulsed	80 – 300	15 – 32	12 – 25 mm	10 – 20 l/min.
1.6	DC (-), DC(+) or pulsed	130 - 350	16 - 32	12 – 25 mm	10 – 20 l/min.

WELDING POSITIONS

NA 1961 is suitable both for downhand and positional welding by adapting transfer mode and welding parameters as for solid wires.

STANDARD DIAMETERS

1.2, 1.6 mm

Other diameters: please consult us

PACKAGING

Diameter	1.2 mm	1.6 mm
	EN ISO 544 – ASME IIC SFA-5.2 M	
Spool type	BS300	
Weight	15 kg	

Other packaging: please consult us