

CARVER 9772

FEATURES

CARVER 9772 is chromium carbide, heavy coated alloy producing a tough deposits that contains a high percentage of extremely hard, finely dispersed multi-carbides for abrasion resistance. It is designed for use in severe abrasion applications for surfacing carbon steel, manganese steel materials. Superior high temperature resistance to 750°C.

APPLICATIONS

Specially designed for applications where welds have to withstand heavy abrasion in service and metal to metal wear. Bucket teeth; Shovel bucket teeth, Bauxite excavators, augers, Chutes, Bucket elevators, ID fan impellers, ash and coal handling pipes.

OPERATIONAL CHARACTERISTICS

- Open arc welding produces sound weld deposits allowing relief cracking.
- High ampere tolerance permits use of variable speed wire feeders and drooping type power sources.
- For optimum performance, use maximum voltage and current.
- To minimize effects of base metal dilution, use two or more layers.

TECHNICAL DATA

Alloy Type	:	Chromium carbide with Mo, Cb, V, and Nb
Machinability	:	Non-machinable
Hardness	:	Rockwell C 62-64

RECOMMENDED CURRENT RANGE

ELECTRODES

SIZE (mm)	3.15	4.00	5.00
AMPS	110-140	150-180	200-260

FLUX CORED WIRES

SIZE (mm)	2.4	2.8	3.2
AMPS	300-350	350-380	430-480

INCREASED METAL
 RECOVERY CHROMIUM CARBIDE ALLOY