

UPW-628

Hardfacing open arc welding wire

Features	UPW-628, a Chromium-Niobium carbide welding wire, is designed to produce a small, uniformly distributed Niobium carbides among in a primary Chromium carbide matrix which can greatly improve high stress abrasion resistance even at moderate impact. The deposited metal will show stress relief cracks and normal service temperature not higher than 500°C.	
Applications	Coal crushers in coal firing power stations, grinding rollers and tables in vertical mill of cement plants, chute and screen in steel and mining industry, and wear plate manufacturing, etc.	
Typical Chemistry	C 5.0%, Mn 0.8%, Si 0.8%, Cr 21.5%, Nb 6.5%	
Hardness	62 ~ 68 HRC (undilited deposit)	
Size	2.8 mm	
Package	Drum packing in 250 kg	
Recommended welding parameters	Voltage	27 ~ 30 V
	Current	300 ~ 450 A
	E.S.O.	30 ~ 40 mm