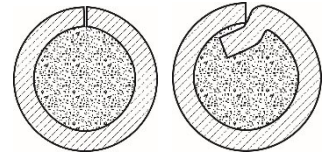


PP-Np-90G13N4*(Np-90Si13Ni4)*

TU U 28.7-21459234-021:2008

Diameter: 1.6 – 4.0 mm
 Shielding: open arc
 Structure: tubular, overlapping

**General description**

Flux-cored wire of **PP-Np-90G13N4** grade is designed for automatic and semi-automatic open arc hardfacing of wear-resistant pads on parts subject to heavy impacts. It is desirable to perform hardfacing down-hand, using reversed polarity direct current.

Welding process properties

Weld formation	- good
Slag separation	- good
Deposit factor, g/A·h	- 10 – 16
Crack susceptibility	- moderate
Wire consumption, kg	- 1.1 – 1.15
Hardness of weld metall	- after hardfacing HB 160 – 240 - after strain-hardening HRC 42 – 50

Operating conditions (open arc)

Wire diameter, mm	Current, A	Voltage, V	Deposition rate, m/h	Wire stick-out, mm
1.6	140 – 220	22 – 24	10 – 14	30 – 40
2.0	180 – 250	23 – 25	12 – 17	30 – 40
2.4	200 – 290	24 – 25	15 – 19	30 – 40
2.8	250 – 350	24 – 26	18 – 22	30 – 40

Properties of weld metall

The weld metall has particularly high plasticity and toughness. After strain-hardening, it is extremely wear-resistant when the wear process involves heavy impact or substantial contact pressure.

Process features

Avoid overheating of the main metall.

In case of multi-pad hardfacing, always hammer the weld pad.

Wire diameters up to 2.2 mm can be supplied on metal spools K-300 (15 kg).

Application

Hardfacing of railway frogs, parts of crushing and milling equipment, resizing and remedy of casting flaws on H13L steel parts, excavator buckets, etc.

