

Chrome Titanium XAB Tubular HF Wire



Chrome Titanium XAB is a true universal tubular hard facing wire that can blend hard materials of different alloys to form a continuous hard surface with extreme resistance to abrasion and high resistance to impact.

Why Makuri

Tubular Hard Facing wire filled with Chromium and Titanium Carbide for use in eXtreme ABrasion (XAB) applications where hard facing of dissimilar metals is required. Can be used without pre heat or use of shielding gases. Can protect and join the hard surfaces of bimetal blocks to AR and Carbide wear plates.

Typical Hardness Rockwell C Scale		Typical Materials Analysis					
Material	Multi Layer Hardness Rc	Cr	Ti	C	Mn	Mo	Si
1 Layer	50+	6.50	5.00	1.80	1.20	0.80	0.70
2 Layer	54+						
3 Layer	58+						

Conditions of Use		Operating Conditions			
Current Type	Shielding	Material (mm)	Amperage (A)	Voltage (V)	Stick-out (mm)
			Range	Range	Range
DC (-)	Self-Shielded	1.6	180 - 300	23 - 28	20 - 30
		2.0	200 - 400	26 - 28	25 - 30
		2.4	250 - 450	26 - 28	25 - 40
		2.8	250 - 450	28 - 28	25 - 40

Packaging			
Diameter	< 2.4 mm	> 2.4 mm	
Standard Packaging (EN ISO 544)	Spool : BS 300	Coil : B 450	Drum
Weight	15 Kg	25 Kg	Up to 330 Kg

Description

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Applications

Chrome Titanium XAB is a true universal tubular hard facing wire that can blend hard materials of different alloys to form a continuous hard surface with extreme resistance to abrasion and high resistance to impact.

Examples

To hard face over, protect and join the installation welds on wear blocks, wear plates and liners of all types as found in Rope Shovel Dippers, Excavator Buckets, Dump Pockets, Feeders and Transfer Chutes



Level 1
5F Guarantee

This is a 'best in class' 5F industrial standard covering all Products and guarantees the **Fit, Form, Function** of such items and that they are also free of defects in **Faulty Workmanship** and **Faulty Materials**.

Products that fail to meet this guarantee are fully replaced or fully credited.

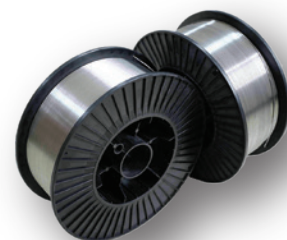
Welding Positions

Flat, Half up, Half down

Classification

EN 14700 T Fe8 55 GP

DIN 8555 MF 6 GF 55 GP



NOTE:

The full range of the MAKURI products can be seen on our website and Process Improvement Handbook or contact us to discuss your application and issues