

CEWELD Powder Nickel 3

| TYPE | Gas atomized Nickel spray powder (NiBSi), suitable for spray - fuse and Cast iron welding. | | | | | | | | | | |
|---------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------|-----|-------|----|-------|-----|------|------|-----|-----|
| APPLICATIONS | CEWELD Powder Nickel 3 is designed for spray and fuse applications. For wear parts that need to outlast new parts where high temperature combined with corrosion and wear resistance is required. Small shafts, the leading edge of screw and centrifuge flights, keyways, splines and cams can all be efficiently coated or rebuilt with this process. Particularly well suited to the protection and restoration of glass container moulds. Also used for the restoration of automotive parts (clutch parts) or for repairing surface flaws in cast iron parts. | | | | | | | | | | |
| PROPERTIES | CEWELD Powder Nickel 3 has excellent corrosion and wear resistance and is suitable for working temperatures up to 950°C. The coatings are gas-tight and metallurgically bonded to the substrates by diffusion. ■ Hardness: HRC 22-27 ■ Can be used up to approx. 960 °C Typical Partical size (µm): 36-106 / 20-106 / 53 - 150 | | | | | | | | | | |
| CLASSIFICATION | EN ISO 14232-1 Ni-B-Si 95/2/3 | | | | | | | | | | |
| SUITABLE FOR | Particularly well suited to the protection and restoration of glass container moulds. Also used for the restoration of automotive parts (clutch parts). Also for repairing surface flaws in cast iron parts. | | | | | | | | | | |
| APPROVALS | | | | | | | | | | | |
| WELDING POSITIONS | | | | | | | | | | | |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th style="border: none;">B</th> <th style="border: none;">Fe</th> <th style="border: none;">Ni</th> <th style="border: none;">Si</th> <th style="border: none;">Other</th> </tr> </thead> <tbody> <tr> <td style="border: none;">1.2</td> <td style="border: none;">0.12</td> <td style="border: none;">Rem.</td> <td style="border: none;">2.7</td> <td style="border: none;">2.5</td> </tr> </tbody> </table> | B | Fe | Ni | Si | Other | 1.2 | 0.12 | Rem. | 2.7 | 2.5 |
| B | Fe | Ni | Si | Other | | | | | | | |
| 1.2 | 0.12 | Rem. | 2.7 | 2.5 | | | | | | | |
| MECHANICAL PROPERTIES | | | | | | | | | | | |
| REDRYING | Not required | | | | | | | | | | |
| GAS ACC. EN ISO 14175 | None | | | | | | | | | | |