CARVER - 9525

carver
ROBOWELD LIMITED

NICKEL-CHROMIUM-MOLYBDENUM ALLOY FOR EXCELLENT TOUGHNESS

SMAW	FCAW	MCW
DC+	DC+, 100% CO2 Or 75% Argon-25% CO2	DC+, 100% CO2 Or 75% Argon-25% Co2 Or 90% Argon-10% CO2

TECHNICAL DATA	
Alloy Type :	Nickel-Chromium-Molybdenum
Tensile Strength :	840 N/mm^2
Elongation :	UP to 23%
Machinability :	Excellent
Hardness :	Rockwell C 25-30
Available Processes :	SMAW, FCAW, SAW & MCW

RECOMMENDED CURRENT RANGE

ELECTRODES	
SIZE (MM)	AMPS
3.15	120-150
4.00	160-190
5.00	200-240

FLUX CORED WIRES		METAL CORED WIRES	
SIZE (MM)	AMPS	SIZE (MM)	AMPS
1.6	270-320	1.6	270-320
2.4	330-370	2.4	330-370

ISO 9001-2015 CERTIFIED
MEMBER
MADE IN INDIA

FEATURES :

This alloy displays excellent toughness while maintaining good machining characteristics. For Joining buildup, and repairing cracked or fractured steels with up to 140,000 psi tensile strengths.

APPLICATIONS :

Use for fabricating structures, machinery, assemblies and repair of heavy duty off the road equipment. It is widely used in the forging industry for the repair of hammer bases, sow blocks, rams, bolster plates columns and keyways. Also used as an underlay prior to surfacing with higher alloys.

PROCEDURE :

Remove all defects; heat checks, spalls, and cracks. Preheat the unit to a minimum of 425°C. Maintain this temperature during welding. Utilize short arc length. Peening is necessary when filling in small cavities. Peen after depositing each pass. Peening is not necessary when welding large areas such as complete impressions except on the final pass. After welding cool the unit in still air to approximately 175°C. This is necessary to produce uniform weld hardness. When the cooling temperature is reached, immediately charge dies into a furnace at 560°C and temper for 12 to 16 hours. On rams and sow blocks, etc..., stress relieve at 620°C for 12 to 16 hours. Stress relieve hammer bases at 620°C at one hour per inch of thickness at temperature. Remove the unit from the furnace and cool in still air to room temperature.

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