

Supershield CrCB

CHROMIUM CARBIDE TYPE OPEN ARC WIRE

HYUNDAI WELDING CO., LTD.



Supershield CrCB

❖ **Specification**

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❖ **Description & Applications**

Supershield CrCB is an open arc wire. It is Chromium Carbide base added boron for hardenability. Used for hardfacing components subject to extreme abrasion and heavy impact.

(Cement roll mill, Gyrotory Crusher, Crusher & Coke Hammers etc.)

❖ **Welding Process**

Open Arc Type

❖ **Current Type**

DC+

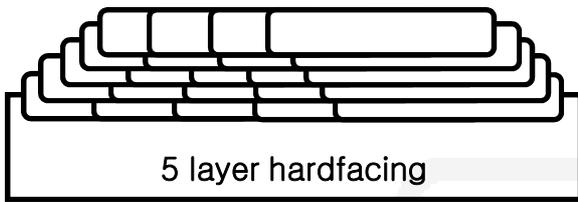
❖ **Packing**

Supershield CrCB	Dia.	3.2mm(1/8in)
	Coil	25kg(55lbs)
	Pailpack	150kg(330lbs), 250kg(551lbs)



Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions



Diameter	: 3.2mm(1/8in)
Welding Type	: Open-Arc
Amp./ Volt.	: 400 / 30
Stick-Out	: 25~30mm(0.98~1.18in)
Pre-Heat	: 150~250℃(302~482°F)
Interpass Temp.	: 200~300℃(392~572°F)
Total layers	: ≥4 layer

❖ Chemical Analysis of All weld metal(wt%)

Consumable	C	Si	Mn	Cr	Ti	B
Supershield CrCB	4.30	0.64	1.35	26.0	0.14	0.25

❖ Hardness test of All weld metal(HRc)

Consumable	Hardness(HRc)					Avg.
Supershield CrCB	59	60	60	62	62	61



Test Results

❖ BEAD APPEARANCE

Consumable	Supershield CrCB
Amp.(A)	380~400
Volt.(V)	28~30
Carrige Speed	40~60cm/min(15.7~23.6in/min)
Welding Position	Flat(1G)



This information is provided solely for the purpose of confirming product conformance with applicable standards. The serviceability of a product or structure utilizing this type of information is and must be the sole responsibility of the builder/user. Many variables beyond the control of HYUNDAI WELDING CO., LTD. affect the results obtained in applying this type of information. These variables include, but are not limited to, welding procedure, shielding gas, plate chemistry and temperature, weldment design, fabrication methods and service requirements.