

Press release

Presse-Information

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Welding Consumables from Kalenborn: Wear Resistant Linings with Flux Cored Wires and Stick Electrodes

With KALMETALL-W Kalenborn offers a comprehensive spectrum of solutions for hard overlay welding. This program is now extended by a high-quality series of welding consumables. The product range includes not only flux cored wires but also stick electrodes. The welding alloys available provide solutions to a variety of wear problems.

The supply spectrum includes:

KALMETALL-WFD flux cored wires as defined in DIN EN14700.

The wire diameter ranges between 1.6 and 2.7 mm. Different package sizes with coils from 15 to 250 kg are offered. Kalenborn also supplies corresponding alloys as KALMETALL-WE stick electrodes. The stick electrodes are supplied as specified in DIN EN 14700. The electrode diameter is from 2.5 to 5 mm.

The electrode alloy chosen for hard overlay welding also depends on the chemical composition of the base material, the specific application, the given surface quality, the deposit thickness and the number of passes as well as the general technical requirements. For each specific application, the wear requirements, the requested toughness, the temperature stress and corrosion, if any, have to be duly considered.

Kalenborn supplies welding consumables on the basis of more than 80 years of experience in solving wear problems. During all these years the company gathered extensive knowledge in welding engineering. Kalenborn offers a wide scope of welding solutions. It is ensured that the correct welding consumable is supplied for the particular wear resistant lining. Furthermore, Kalenborn offer combinations with other abrasion resistant metallic and ceramic materials to optimize the relevant application from a technical and economic point of view.



Hard-facing of plant components with flux cored wires or stick electrodes



KALMETALL-WFD flux cored wires and
KALMETALL-WE stick electrodes

Technical Data of KALMETALL-WFD flux cored wired (reference values)

KALMETALL	Chemical composition of the welding consumables %						Max. hard-ness VH	Max. appl. temp. °C/°F	Resistant against		
	C	Cr	Mo	Nb	B	Fe			Abrasion	Impact	Temp.
W 100 FD	5	28	-	-	-	60	700	350/662	XX	X	X
W 143 FD	5	22	-	7	-	60	740	350/662	XXX	X	X
W 145 FD	5	21	7	7	-	60	800	750/1382	XXX	X	XXX
W 150 FD	4	22	-	-	1	66	820	350/662	XXXX	-	X
W 151 FD	5	30	3	-	-	57	820	550/1022	XXXX	X	XX

Technical data of KALMETALL-WFD flux cored wires
(reference values)