

Typical Applications

- Suitable for mixer paddles, grinding rollers and grinding paths.
- Sinter finger crushers, mixer blades, exhaust fan blades.
- Burden area in blast furnace bells, blast furnace charging systems.
- Crushing and screening plants, bucket teeth and lips.

Standards

EN 14700 T Fe 16

General Characteristics

AbraHARD® 9800 is C, Cr, Mo, Nb, W, V alloyed open arc flux cored wire. It provides ultimate wear resistance up to 800 °C.

Weld deposit is suitable to components subject to extremely strong abrasive mineral wear and moderate impact due to primary and eutectic Cr, Nb, W and V-carbides in austenitic matrix.

Wear Resistance

Impact	Metal to Metal	Abrasion
☆☆☆☆★★	☆☆☆☆★★	★★★★★★

Welding Positions, Polarity and Shielding Gas

Welding Positions : PA, PB, PC
Shielding Gas : Not Required
Polarity : DC (+)

Microstructure

Austenitic matrix with complex carbides of different types. Chromium rich hexagonal primary carbides, eutectic carbides and nodular Niobium carbides.

Typical Mechanical Properties (All Weld Metal)

Heat Treatment	Welding Sequence	Hardness (HRc)
As Welded	3. Layer	63-65

Packaging & Diameter Details

Product Code	Diameter (mm)	Packaging Options
-	1.60	15 Kgs Spools (BS 300)
-	2.00	25 Kgs Spools (BS 450)
-	2.40	250/300 Kgs (Drums)
-	2.80	

Recommended Operating Parameters

Diameter (mm)	Current (A)	Voltage (V)
1.60	160 - 260	20-26
2.00	240 - 280	22-26
2.40	280 - 340	24-27
2.80	320 - 400	25-28

Storage Informations

Products should be stored in moisture free room on wooden, composit or plastic pallets.