

Panzercrom® AbraHARD 9200

Open Arc Flux Cored Wire - Hardfacing



Typical Applications

- Suitable for pumps, mixer parts, stirring paddles.
- Concrete pumps, conveyor screws, coke oven carriages.
- Catalytic pipes, dredge cutters, shovel bucket teeth.

Standards

EN 14700 T Z Fe 14

General Characteristics

AbraHARD® 9200 is an open arc flux cored wire provides high C and Cr alloyed weld metal with excellent resistance to high abrasion. The deposit readily show stress relief cracks.

Best result can be achieved by welding in two layers. Maximum 10 mm of deposit thickness recommended. Before hardfacing of crack sensitive base materials or overlaying of pre-hardfaced surfaces, buffering with BuildHARD® 4200 or BuildHARD® 4300 layer is recommended.

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

Homogeneously dispersed primary carbides and eutectic carbides in an austenitic matrix.

Typical Mechanical Properties

Hardness : 60-62 HRc

Packaging & Diameter Details

Product Code	Diameter (mm)	Packaging Options
-	1.20	
-	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)
1.20	140 - 260	20-25
1.60	180 - 300	22-27
2.00	220 - 350	24-28
2.40	240 - 360	26-30
2.80	300 - 420	27-30

Storage Informations

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