

NIMOTEN 9650

HARD FACING (Galling & Metal to Metal Wear Resistance)

ALLOY BASIS:

C, Cr, Mo, W, V

KEY FEATURES:




- Martensitic stainless steel weld free from cracks
- Resistant to galling
- High metal to metal wear resistance
- Easy slag removal & radiographic quality welds
- Excellent welder appeal
- Machinable with carbide tools

TYPICAL APPLICATIONS:


- Hammer, Impactor & Screw press dies
- Hot working tools & guides
- Weld surfacing of new dies and reclamation of wear out hot forging dies

PHYSICAL PROPERTIES:

Condition	3 Layer Hardness, HRC
As welded	43-47
SR at 550°C for 2 hours	40-45

Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
			

PARAMETERS - PACKING DATA:

Ø x L, mm 3.15 x 450 4.0 x 450 5.0 x 450	Amperage, A 100-140 150-180 190-250	 AC (70 V)/DCEP REDRYING CONDITION: 200-300°C for minimum 1 hour
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Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kg each. Also available in vacuum packing

Physical Properties: With increase in number of squares, property improves