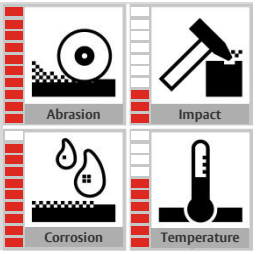
VAUTID Ultra 303

Coated nickel core wire
Deposition welding material for extremely abrasion and corrosion-resistant hard coatings

VAUTID®

VAUTID Material characteristics



Specification	**Coated electrode DIN EN 14700 E Ni20 cgtz**
Material type **Alloy components**	NiCrBSi - Basic material with embedded matrix-independent, broken tungsten carbides with a grain size of 0.3 - 0.7 mm. The use of other grain sizes of the tungsten carbide or the use of spherical tungsten carbide is possible if required Ni – Cr – B – Si – W2C – WC
Weld deposit characteristics	Wear-resistant against cavitation, sliding, groove, grain gliding and grain roll wear. High corrosion resistance, e. g. to water (including seawater), weathering, caustic soda, diluted sulphuric, phosphoric, formic and acetic acid
Weld deposit properties	Hardness of the matrix: ca. 400 - 600 HV10* Tungsten carbide: ca. 2000 HV10* (DIN 32525-4)
Recommended applications	Parts of sand preparation plants, excavator buckets, mixers, slurry pumps, screw conveyors, grinding segments, mill hammers, augers, peeler blades, impact bars, guide rails of straightening machines
Standard sizes	Coated nickel core wire: Diameter 4,0 / 5,0 / 6,0 / 8,0 mm Packing: Spools with ca. 15 kg

* subject to common industrial fluctuations

Welding instructions:

VAUTID Ultra 303 is usually welded with an oxygen-acetylene flame. The flame is slightly excess oxygen.

The workpiece should be cleaned by regrinding. Local preheating to 300 - 400° C is required for regrinding. Heat the base material with the flame, do not melt. Melt the wire in contact with the workpiece.

In order to avoid a strong oxidation of the material surface, the workpiece can be sprayed with NiCrB powder after regrinding.

Welding position (EN ISO 6947): PA

This data sheet corresponds to the present state of production (October 2016) and can be changed anytime.

VAUTID GROUP
Brunnwiesenstr. 5
73760 Ostfildern

Telefon: + 49 711 / 44 04-0
Fax: + 49 711 / 44 20 39

E-Mail: vautid@vautid.de
Web: www.vautid.com