



# ISAFIL 62

## Stuffed wire for reloading

Classification DIN EN 14700 : T Ni20 (DIN8555 : MF21-55-CGZ)

### Properties:

**ISAFIL 62** is a self-protective stuffed wire, Ni-Cr-B-Si alloy with incorporated tungsten carbides, highly resistant to wear and with superb abrasion resistance, **ISAFIL 62** also has very good resistance to temperature and corrosion.

### Applications :

Specially developed for recharging tools for the drilling industry as well as ferritic and austenitic components for the chemical and food industry (olive press).

It is ideal for reloading endless screw spires, cutting wheel tools for tunnellers, shakers and swirler blades, head screws for brick molders, the deposit is only machineable by grinding.

### Hardness :

Melted tungsten carbide : 2360 HV0,1

### Matrice :

450 - 480 HV0,1

### Abrasion resistance :



### Welding recommandations :

Ø mm	Coil DIN EN 759	Amperes	Voltage
1,6	B 300 Couronne / ca.15 kg	120 - 160	16 - 18
2,0	B 300 Couronne / ca.15 kg	160 - 180	18 - 20
2,4	B 435 Couronne / ca.25 kg	200 - 230	21 - 23
2,8	B 435 Couronne / ca.25 kg	220 - 260	21 - 23

### Transformation indications :

A crack-free recharging is only possible with meticulous thermal management. The preheating temperature should be as high as possible depending on the base material. Keep cooling slowly. The alloy can be supplied on request, both for gas-protected welding as well as for OPEN ARC welding. Basically, it is important to work with the lowest possible welding voltage.

### Patents :

Germany : No. 40 08 091.9-41 // UK : No. 2.232.108 // USA : No. 5.004.886

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