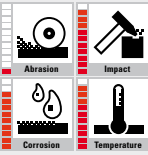
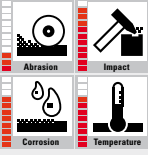
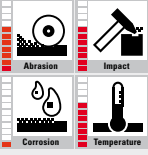
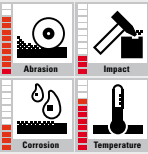


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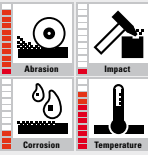
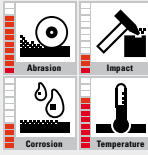


VAUTID Hardfacing Materials

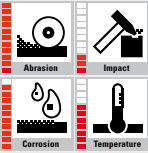
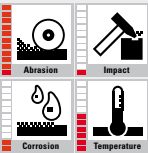
VAUTID Hardfacing Welding Programme on Iron Base

Forms of stress	Applications	VAUTID Type	Form	Alloy type	Hardness Vickers HV 30	Hardness Rockwell HRC
	buffer layers, rails, parts for chemical industry, joint welding	18/8/6	stick electrode tubular wire	X15CrNiMn1886	200 400*	40*
	buffer layers, rails, parts for chemical industry, for materials difficult to weld	30/9 (29/9)	stick electrode tubular wire	X10CrNi309	210	
	build-up and buffer layers, idlers	V 30	stick electrode tubular wire	low alloyed Fe, Cr, Si, Mn	300	30
	crushing heads, hammers for crushers, crushing jaws	V 50 (beta)	stick electrode tubular wire	high alloyed Fe, Cr, C, Mn	220 520*	10 50*
	crushing heads, hammers for crushers, crushing jaws	V 60 (gamma)	tubular wire	high alloyed Fe, Cr, C, Mn	220 450*	10 45*
	crushing jaws, dredger teeth	V 40 (alpha)	stick electrode tubular wire	high alloyed Fe, Cr, C, Mo	600	54
	sealing surfaces, impact bars, hammers for crushers	V 70 (delta)	stick electrode tubular wire	high alloyed Fe, Cr, C, Ti	650	57
	cone crushers, pick hammers, dredger teeth	V 80	tubular wire	high alloyed Fe, Cr, C, Mo	600	54
	top layer for hammers, excavator teeth, mixing blades	V 143	stick electrode tubular wire	high alloyed Fe, Cr, C, Nb	800	63
	screws, scrapers, mixer blades, chainwheels, top layer for teeth tips, crusher jaws	V 100	stick electrode tubular wire	high alloyed Fe, Cr, C	750	62
	screws, dredging bucket front edges, sieves, stirrer blades, top layer for teeth tips and crushing rolls	V 100 Mo	tubular wire	high alloyed Fe, Cr, C, Mo	750	62
	conveyor screws, bucket teeth, crusher jaws, grinding rollers	V 105	tubular wire	high alloyed Fe, Cr, B	800	63
	hammers for crushers, punching tools, shearing blades, drill heads	V 110	stick electrode	high alloyed Fe, Cr, C, Mo, V	690	59
	screws, gravel pumps, bunbury mixers	V 150	stick electrode tubular wire	high alloyed Fe, Cr, C, B	880	66

VAUTID Hardfacing Welding Programme on Iron Base

Forms of stress	Applications	VAUTID Type	Form	Alloy type	Hardness Vickers HV 30	Hardness Rockwell HRC
	sinter bars, coke pushers	V 100 T	stick electrode tubular wire	high alloyed Fe, Cr, C	750	62
	sinter crushers and bars	V 145	stick electrode tubular wire	high alloyed Fe, Cr, C, Mo, Nb, W, V	850	65
	furnace top bell facing, hot dust ducts, screens, sinter crushers, mixer components	V 146 Mining (V 176)	tubular wire	high alloyed Fe, Cr, C, V, Nb, B	850	65
	furnace top bell facing, hot dust ducts, screens, sinter crushers	V 147	stick electrode tubular wire	high alloyed Fe, Cr, C, Si, B	850	65
	furnace top bell facing, hot dust ducts, screens, sinter crushers	V 149 Everlast	tubular wire	high alloyed Fe, Cr, C, Mo, Nb, W, B	1100	70
	mixer components for parts attacked by corrosion	V 100 C (V 100 K)	stick electrode tubular wire	high alloyed Fe, Cr, C, Ni, Mo	450	45
					*cold hardened	*cold hardened

VAUTID Hardfacing Programme on Tungsten Carbide Base

Forms of stress	Applications	VAUTID Type	Form	Alloy type	Hardness Vickers HV 30
	scrapers, edges of augers, hammers, drill bits, cutting tools, impact bars	V Ultra 303 (Ultra III)	coated wire	W2C in nickel matrix	matrix: 500 HV W2C-grain: 2000 HV
	scrapers, edges of augers, hammers, drill bits, cutting tools, impact bars	V Ultra 305 (Ultra V)	tubular wire	W2C in nickel matrix	matrix: 600 HV W2C-grain: 2000 HV
	edges of augers, rock drills, mixer blades	V Ultra 301 (Ultra I)	stick electrode	W2C in iron matrix	matrix: 600 HV W2C-grain: 2000 HV
	scrapers, plough shares, grinding segments	V Ultra 302 (Ultra II)	stick electrode	W2C in iron matrix	matrix: 850 HV W2C-grain: 2000 HV
	scrapers, plough shares, grinding segments	V Ultra 304 (Ultra IV)	tubular wire	W2C in iron matrix	matrix: 850 HV W2C-grain: 2000 HV



VAUTID
Hardfacing
Materials

Repair and Buffer	Impact	Impact and Abrasion	Abrasion	Temperature and Abrasion	Corrosion and Abrasion	Extremely high Abrasion
18/8/6	V 50	V 40	V 100	V 100 T	V 100 C	V Ultra 301
30/9	V 60	V 70	V 100 Mo	V 145	V Ultra 303	V Ultra 302
V 30		V 80	V 105	V 146 Mining	V Ultra 305	V Ultra 303
		V 143	V 110	V 147		V Ultra 304
			V 150	V 149 Everlast		V Ultra 305
						V 149 Everlast

Hardfacing materials as stick electrodes

Tubular wire production, the fast and economical solution of wear problems on site

Tubular wire also to receive in barrels like all hardfacing materials from own production

