

**PRIME
WELD**

PRIME H33-0

Flux Cored Wire
For Hard Surfacing

Classifications:
EN ISO 14700 : E Fe 14

Welding Positions:



Characteristics and Applications:

PRIME H33-0 is a self-shielded chrome carbide flux cored wire for hardfacing components subject to extremely severe abrasive wear and moderate impact and moderate corrosion resistance. The deposit contains high proportion of hard primary carbon and eutectic carbides in a tough austenitic matrix. Design to use in hardfacing palm oil mill screw and high pressure kernal worms. Ideal also palm oil expeller screw, dredge pump impellers, crusher cones and sugar mill crusher hammer.

Chemical Properties of Weld Metal (Wt%)

C	Mn	Si	Cr	P	S
4.51	1.05	0.85	25.01	0.013	0.011

Deposit Rating Scale

ABRASION	1	2	3	4	5	6	7	8	9	10
IMPACTS										
HEAT										
CORROSION										

- Single layer deposit hardness may vary depending on the base material metal type and degree of dilution.

Hardness (as-welded) : 58 - 63 HRC

Deposit thickness : 2 passes maximum

Sizes Available and Recommended Currents (DC-)

Diameter (mm)	1.6	2.0
Current (A)	180-300	200-340
Voltage (V)	22-28	24-32
Spool (Kg)	15	15

**PRIME
WELD**

PRIME H33Nb-0

Flux Cored Wire
For Hard Surfacing

Classifications:
EN ISO 14700 : T Fe 15

Welding Positions:



Characteristics and Applications:

PRIME H33Nb-0 is a self-shielded chrome carbide flux cored wire depositing extremely hard abrasion resistant Chromium-Niobium carbides in an austenitic matrix. It is ideal for hard surfacing applications when resistance to extreme abrasion, heavy impact, heat and corrosion resistance up to 450°C (842°F) are required. Typical applications include palm oil mill screw and high pressure kernal worms screw, vertical crushers, oil expeller screws, mineral conveying equipment, bucket wheel excavator, shovel bucket teeth and etc.

Chemical Properties of Weld Metal (Wt%)

C	Mn	Si	Cr	Nb	S	P
4.90	0.85	0.70	21.80	7	0.011	0.013

Deposit Rating Scale

ABRASION	1	2	3	4	5	6	7	8	9	10
IMPACTS										
HEAT										
CORROSION										

- Single layer deposit hardness may vary depending on the base material metal type and degree of dilution.

Hardness (as-welded) : 60 - 65 HRC

Deposit thickness : 2 passes maximum

Sizes Available and Recommended Currents (DC-)

Diameter (mm)	1.6	2.0
Current (A)	180-300	200-340
Voltage (V)	22-28	24-32
Spool (Kg)	15	15