

VORAX EXTREME CR COMPOSITE TUNGSTEN CARBIDE HARDFACING RODS

CHARACTERISTICS

VORAX EXTREME CR composite rods are made of 60% sintered tungsten carbide fragments in a ductile Cu-Ni-Zn matrix with either sharp-edged cutting grade carbides for milling and cutting operations, or with slightly rounded edges for applications such as stabilizers and wear pads. **VORAX EXTREME CR** alloy exhibits a tensile strength of 100,000 psi. **EXTREME CR** production methods ensure homogeneous distribution of the sintered tungsten carbide particles. **VORAX EXTREME CR** composite rods can be applied with an oxy-fuel torch.

WELDING RECOMMENDATION

The area to be hard faced should be free of rust, scale, grease or other contamination. Slowly preheat the area to a maximum of 480°C to insure proper wetting of the carbides to the metal substrate. Once the area is properly heated, prior to hardfacing with **VORAX EXTREME CR** composite rods, **VORAX TINNING RODS** in a thickness of 1mm should be brazed to the surface.

STANDARD CARBIDE CONTENT	OTHER PERCENTAGES	CARBIDE GRAIN SIZE:				
60%	40%, 50%, 70%	1/16"	3/16"	1/4"	5/16"	1/2"
		✓	✓	✓	✓	✓

NOTES

Do not overheat the hard faced area. Particles can be arranged in correct position and dense configuration by using the end of the **VORAX TINNING RODS**. Slow cooling is advised. Never cool area with water! Other grain sizes available on request. Standard **VORAX EXTREME CR** composite rod length is 450mm.

