VAUTID Ultra 303
Coated nickel core wire
Deposition welding material for extremely abrasion and corrosion-resistant hard coatings

**Specification**

<table>
<thead>
<tr>
<th>Material type</th>
<th>Coated electrode DIN EN 14700 E Ni20 cg tz</th>
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<tbody>
<tr>
<td>Material type</td>
<td>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</td>
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<tr>
<td><strong>Weld deposit characteristics</strong></td>
<td>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</td>
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</tbody>
</table>
| **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

**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.