

**PRONAMIC® H1 wire**

**PRONAMIC® H1 wire** is a self-shielded flux-cored wire for welding.

The undiluted deposit contains dense and uniform distribution of primary chromium carbides and eutectic carbides of the  $M_7C_3$  type. The surface appearance is typical for this type of hardface, with a family of stress-relief cracks (“check cracks”).

**Applications**

**PRONAMIC® H1** welding wire is used for

- manufacturing of **PRONAMIC®** tires and grinding plates for vertical mills
- refurbishment of **PRONAMIC®** tires and grinding plates, even over existing worn deposits, using **LOESCHE** approved procedures
- refurbishment of worn high chromium white irons, using **LOESCHE** approved procedures
- salvage/localized repairs of high chromium cast iron tires and grinding plates
- refurbishment of **PRONAMIC®** tires and grinding plates.

**Restrictions**

This welding wire should not be applied over bare steel castings.

Repair of high chromium cast iron parts is not recommended due to the propensity to brittle fracture. Salvage repairs may be carried out under controlled conditions to achieve some extension in component service life; for best results, use **LOESCHE** materials, processes, and supervision.

**Specifications**

**PRONAMIC® H1** wire complies with EN14700, type T Fe16.

Typical chemical composition (wt. %) of undiluted weld metal				
C	Si	Mn	Cr	Fe
5.5	1.2	0.3	27.0	Balance
Hardness, undiluted 3 layers deposit				
61-65		HRC		
Recommended welding parameters				
Diameter (mm)	Current (A)	Voltage (V)	Stickout (mm)	
1.6 - optimum range	150 - 300	24 - 30	15 - 25	
2.8 - optimum range	450 - 550	30 - 32	30 - 40	
2.8 - extended range	300 - 550	29 - 32	30 - 40	
Standard diameters (mm):				
1.6 and 2.8 (for other diameters please consult <i>LOESCHE</i> )				
Packing				
Diameter	1.6 mm		2.8 mm	
Standard packing	Spool: BS 300		Drum	
Weight	15 kg		Up to 300 kg (standard 250 kg)	

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.