

**Pronamic® T2 wire**

Pronamic® T2 wire is a self-shielded flux-cored wire for welding.

The undiluted deposit contains dense and uniform distribution of primary chromium carbides and complex niobium, molybdenum, tungsten and vanadium carbides. The surface appearance is typical for this type of hardface, with a family of stress-relief cracks (“check cracks”).

**Applications**

Pronamic® T2 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 Pronamic® approved procedures
- refurbishment of worn high chromium white irons, using Pronamic® approved procedures

Restriction: Pronamic® T2 wire should be limited to 3 layers and should not be applied over bare steel castings.

**Specifications**

Pronamic® T2 wire complies with EN14700, type T Z Fe16.

Typical chemical composition (wt. %) of undiluted weld metal									
C	Si	Mn	Cr	Mo	W	V	Nb	B	Fe
5.5	1.0	0.2	21.0	6.5	2.0	0.8	6.0	0.03	Balance
Hardness									
61-67	HRc								
Recommended welding parameters (Ø 2.8 mm)									
Current (A)		Voltage (V)			Stickout (mm)				
450 - 550		30 - 32			30 - 40				
Packing									
Pack		Drum (Ø 546 mm)							
Weight/pack		250 kg (nominal)							

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.