

# MARTEC

RCS ANGERS B 403 909 724

## MADUR® Hardfacing products

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# MADUR<sup>®</sup> hardfacing flexible cords

MADUR<sup>®</sup> cord is a flexible cord composed of fused Tungsten Carbide grains mixed in a Nickel base matrix, hardness 40 HRc. Fused Tungsten Carbide grains are cast or spherical particles.



MADUR<sup>®</sup> cord is applied using an oxyacetylene torch.



It is advisable to spray first an underlayer of powder to avoid oxidation of the parts.



Item Cord	Fused Tungsten Carbide		Available diameters			
	Size	Type	Diam. 5	Diam. 6,5	Diam. 8	
Cast tungsten carbide	MADUR <sup>®</sup> 8202	106-150 µm	Cast	15.8202.05	15.8202.06	15.8202.08
	MADUR <sup>®</sup> 8205	106-500 µm	Cast	15.8205.05	15.8205.06	15.8205.08
	MADUR <sup>®</sup> 8208	106-800 µm	Cast	15.8208.05	15.8208.06	15.8208.08
	MADUR <sup>®</sup> 8212	106-1200 µm	Cast	15.8212.05	15.8212.06	15.8212.08
	MADUR <sup>®</sup> 8220	106-2000 µm	Cast		15.8220.06	15.8220.08
	MADUR <sup>®</sup> 8305 Matrix hardness 30 HRC	106-500 µm	Cast	15.8305.05	15.8305.06	15.8305.08
	MADUR <sup>®</sup> 8308 Matrix hardness 30 HRC	106-800 µm	Cast	15.8308.05	15.8308.06	15.8308.08
Spherical tungsten carbide	MADUR <sup>®</sup> 9202	45-150 µm	Spherical	15.9202.05	15.9202.06	15.9202.08
	MADUR <sup>®</sup> 9205	90-500 µm	Spherical	15.9205.05	15.9205.06	15.9205.08
	MADUR <sup>®</sup> 9208	90-800 µm	Spherical	15.9208.05	15.9208.06	15.9208.08
	MADUR <sup>®</sup> 9502	40-80 µm	Cast	15.9502.05	15.9502.06	15.9502.08
		45-150 µm	Spherical			
	MADUR <sup>®</sup> 9505	106-250 µm	Cast	15.9505.05	15.9505.06	15.9505.08
		250-500 µm	Spherical			
MADUR <sup>®</sup> 9508	106-400 µm	Cast	15.9508.05	15.9508.06	15.9508.08	
	400-800 µm	Spherical				

# MADUR<sup>®</sup> hardfacing powders

Two ranges of MADUR<sup>®</sup> powders:

- \* Nickel-based hardfacing powders with a hardness from 20 to 60 HRC.
- \* Nickel-based hardfacing powders pre-mixed with crushed or pellets fused tungsten carbide with a hardness of 60 HRC.



MADUR<sup>®</sup> powders are applied using an oxy-acetylene torch.

Nickel-based hardfacing powders



Item powder	Alloy	Hardness	Carbide grains content	Carbide grains size	Melting temperature	Packaging		
						0,5 kg	1 kg	5 kg
MADUR <sup>®</sup> 20010	Nickel-Chromium	20 HRC			1090°C	11.20010.05	11.20010.10	11.20010.50
MADUR <sup>®</sup> 30010	Nickel-Chromium	30 HRC			1070°C	11.30010.05	11.30010.10	11.30010.50
MADUR <sup>®</sup> 40010	Nickel-Chromium	40 HRC			1060°C	11.40010.05	11.40010.10	11.40010.50
MADUR <sup>®</sup> 60010	Nickel-Chromium	60 HRC			1040°C	11.60010.05	11.60010.10	11.60010.50

Pre-mixed Nickel-based powders with carbide grains



MADUR <sup>®</sup> 62010	Nickel-Chromium	60 HRC	20% Crushed	40 to 80 µm	1040°C	11.62010.05	11.62010.10	
MADUR <sup>®</sup> 63510	Nickel-Chromium	60 HRC	35% Crushed	40 to 80 µm	1040°C	11.63510.05	11.63510.10	
MADUR <sup>®</sup> 64010	Nickel-Chromium	60 HRC	40% Crushed	40 to 80 µm	1040°C	11.64010.05	11.64010.10	
MADUR <sup>®</sup> 64015	Nickel-Chromium	60 HRC	40% Pellets	40 to 150 µm	1040°C	11.64015.05	11.64015.10	
MADUR <sup>®</sup> 64510	Nickel-Chromium	60 HRC	45% Crushed	40 to 80 µm	1040°C	11.64510.05	11.64510.10	
MADUR <sup>®</sup> 65010	Nickel-Chromium	60 HRC	50% Crushed	40 to 80 µm	1040°C	11.65010.05	11.65010.10	
MADUR <sup>®</sup> 65015	Nickel-Chromium	60 HRC	50% Pellets	40 to 150 µm	1040°C	11.65015.05	11.65015.10	
MADUR <sup>®</sup> 66010	Nickel-Chromium	60 HRC	60% Crushed	40 to 80 µm	1040°C	11.66010.05	11.66010.10	
MADUR <sup>®</sup> 66015	Nickel-Chromium	60 HRC	60% Pellets	40 to 150 µm	1040°C	11.66015.05	11.66015.10	

## MADUR<sup>®</sup> hardfacing electrodes

Contact us



## MADUR<sup>®</sup> flux wire cored for hardfacing

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# Torch cases

2 types of torch cases are available according to your needs of hardfacing:

\* **NATIONAL** torch case designed for thick deposits of cord and powder.

\* **MEDIO** torch case designed for fine deposits especially used in the glass industry.



The picture shows a NATIONAL case

Cases equipment		NATIONAL case ref. 20.009	MEDIO case ref. 20.008
Case	20.001	1	
Case	20.002		1
Mixer	20.016		1
Handle	20.017		1
Mixer	20.018	1	
Handle	20.019	1	
Powder gun nr 4	20.020	1	
Powder gun nr 6	20.022	1	
Cord gun nr 5	20.023	1	
Powder gun nr 1	20.026		1
Powder gun nr 2	20.027		1
Powder gun nr 3	20.028		1
Aluminium hopper	20.032	1	1
Powder tube for mixer	20.033	5	5
Sealing for mixer	20.034	1	1
Spanner	20.035	1	1
Tips cleaner	20.036	1	1

Cases equipment		NATIONAL case ref. 20.009	MEDIO case ref. 20.008
Lighter	20.038	1	1
Acetylene connection	20.065	1	1
Oxygen connection	20.066	1	1
MADUR® powder 20010	11.20010.05		0,5 Kg
MADUR® powder 30010	11.30010.05		0,5 Kg
MADUR® powder 40010	11.40010.10	1 Kg	1 Kg
MADUR® powder 60010	11.60010.05	0,5 Kg	
MADUR® powder 62010	11.62010.05	0,5 Kg	
MADUR® powder 64010	11.64010.05	0,5 Kg	