

**CHROMEWELD FLOW** is a unique piping system that is ideal for material movement with high levels of abrasion resistance. It is a premium grade of chromium carbide wear pipe, providing up to ten times the life of a carbon steel pipe. It is produced with a steel pipe and hardfaced/overlayed with welding wire. CHROMEWELD FLOW will yield outstanding results if you follow these helpful instructions.

## Fabrication Facts

**Cutting:** Plasma burning, air arc, abrasive saw cutting, or waterjet.

**Machining:** The overlay surface can be finished by grinding only. EDM, plasma arc cutting, or carbon-arc gouging may produce countersunk holes for bolts. Pre-machined mild steel inserts may be welded into straight holes for additional machining. CHROMEWELD FLOW cannot be machined by ordinary methods.

**Cold Bending:** Material is not readily formable.

**Welding:** CHROMEWELD FLOW overlay pipe can be joined by welding substrate to substrate using 309 weld wire/rod. Fittings include bends, elbows, tees and reducers. All interior weld seams and all other joints exposed to wear should be protected by a cap weld of CHROMEWELD FUSION.

## Mechanical Information

CHROMEWELD FLOW typical hardness ranges from 52-56 HRC with a single weld pass thickness. On a double weld pass the hardness increases to 58-62 HRC.

## General Overlay Chemistry

- » Diameters Available from 5" – 48"
- » Lengths will vary based on diameter of the pipe.
- » CHROMEWELD FLOW displays excellent abrasion resistance and will withstand continuous moderate impact.
- » CHROMEWELD FLOW overlay will remain abrasion resistant at temperatures up to 1100 degrees Fahrenheit.
- » Standard wall thicknesses range from:
  - Single Pass 1/8" – 3/16"
  - Double Pass 1/4" – 3/8"
- » Your specific application needs, including custom requirements (thickness, alloy and size), are capable at JADCO.



The JADCO process produces a microstructure consisting of fully austenitic matrix filled with primary carbides. This structure provides outstanding abrasion resistance in the most challenging applications.

## Applications

Coal Processing	Power Generation	Pulp and Paper
Dredging Lines	Sand Slurry	Mining Back