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(21) International Application Number: PCT/SE97/01601 (22) International Filing Date: 23 September 1997 (23.09.97) (30) Priority Data: 9603486-3 23 September 1996 (23.09.96) SE (71) Applicant (for all designated States except US): HÖGANÄS AB [SE/SE]; S-263 83 Höganäs (SE). (72) Inventors; and (75) Inventors/Applicants (for US only): HALLÉN, Hans [SE/SE]; Geijersgatan 6, S-254 40 Helsingborg (SE). JOHANSSON, Karl-Erik [SE/SE]; Oscarsgatan 6, S-263 36 Höganäs (SE). (74) Agent: AWAPATENT AB; P.O. Box 5117, S-200 71 Malmö (SE).		(81) Designated States: AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CU, CZ, DE, DK, EE, ES, FI, GB, GE, GH, HU, IL, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, UA, UG, US, UZ, VN, YU, ZW, ARIPO patent (GH, KE, LS, MW, SD, SZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG). Published <i>With international search report.</i> <i>Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments.</i>
(54) Title: USE OF A METAL POWDER FOR SURFACE COATING BY SUBMERGED ARC WELDING (57) Abstract The present invention concerns the use of a pre-alloyed atomised powder in combination with at least one melting electrode wire in the SAW method. The electrode wire is an unalloyed or low-alloy metal wire and the metal powder is a metal powder containing a higher percentage of alloying elements than the electrode wire.		

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USE OF A METAL POWDER FOR SURFACE COATING BY SUBMERGED ARC WELDING

The present invention concerns a metal powder for submerged arc welding. Specifically the invention concerns the use of high-alloy metal powders for surface coating of a metal substrate by the submerged arc welding method.

The submerged arc welding (SAW) method is a well known method, the principle of which is described in eg Chapter 28 of Welding Handbook No 2, 4th Edition, (1958) Section 2, Welding Processes, which is hereby incorporated by reference.

At present the SAW method is considered to be a very rational method for welding and surface coating. Even though this method is highly rational there is an interest to increase its productivity. One way of increasing the productivity is to use multi-wire systems in combination with high amperage. Another way is to add carefully measured amounts of metal powders to the weld joint during the whole welding process. The metal powder can be added either by "forward feed" which means that the powder is fed in front of the flux feed and the electrode wire, or by "direct feed" which means that the powder is magnetically attached to the electrode wire(s). The metal powders currently used are essentially unalloyed metal powders, whereas the elements of the desired for the final joint and the composition thereof is decided by the electrode wire(s) or electrode cord(s), which contain high amounts of alloying elements.

According to the present invention it has now been found that the SAW method can be improved by using a prealloyed, atomised metal powder containing high amounts of alloying elements in combination with at least one melting electrode wire or cord consisting of unalloyed or low-alloy metal. It is essential that the powder is

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prealloyed as otherwise it will not be possible to obtain a uniform coating. Another important feature is that the powder is provided on the outside of or separate from the electrode wire used in the SAW method.

5 Especially important advantages are obtained when the method according to the present invention is applied for surface coating of metal substrates such as low alloy steel substrates which have to be coated in order to increase the hardness, the strength, the oxidation and
10 the wear resistance. The problems with currently used coating methods concern low productivity and comparatively high dilution of the metal substrate surface. A consequence of the high dilution is that several layers and large amounts of the alloying material are required
15 in order to obtain a surface coating having the desired composition and properties. In brief this means that the coated substrates obtained by the currently used methods are expensive and the productivity is low.

US patent 2 810 063 discloses a method, wherein a
20 metal powder is used for submerged arc welding. The powders specifically used in this patent include ferrochromium, ferromanganese and ferromolybdenum in combination with a soft iron powder and a sodium silicate. A distinguishing feature according to this patent is the
25 presence of the iron powder which is essential in order to make the alloying elements magnetically associated with the electrode rod or wire. Problems are, however, encountered with the uniformity of surface coatings obtained with these powders as the different components of
30 the powder mixture easily segregate.

This disadvantage, which in practice makes the method according to the US patent unacceptable for industrial applications, where a high degree of uniformity is required, can be avoided by using a prealloyed metal
35 powder according to the present invention.

A method similar to that according to the US patent 2 810 063 is disclosed in the US patent 2 191 471.

By using a prealloyed powder according to the present invention, it has been found that not only a very
5 uniform structure can be obtained but also that the microstructure will be finer. The risk of obtaining microcracks in the coating is thus reduced and the strength is higher. By supplying the prealloyed powder separately, i.e. by forward feeding the powder, or on the
10 outside of the electrode surface i.e. by feeding the powder magnetically attached to the outside of electrode(s), the melted substrate surface is efficiently cooled and the melting bath can be reduced. The amounts of expensive alloying elements can be decreased due to
15 the fact the alloying elements are not diluted to the same extent as when the major part of the alloying elements are included in the melting electrode wire or cord. An additional advantage is that the surfacing or coating rate can be increased. It has thus been found
20 the for a given area to be coated the productivity is three times as high as when the open arc method is used. In comparison with coating according to the conventional SAW method, i.e. where the material of the electrode is comparatively high alloyed and the metal powder
25 essentially unalloyed, the present invention offers an improvement of about 50 percent.

The type and the amount of metal powder are selected in such a way that the powder in combination with the electrode wire gives the desired coating composition
30 of the substrate. The powder, which can be magnetic or non-magnetic powder, can be selected from a wide variety of available powders. If the powder is magnetic it can be fed or transported to the substrate together with and fixed on a (magnetic) electrode wire. Magnetic powders
35 are especially preferred for coating rolls. If non-mag-

netic, the metal powder is fed directly to or in front of the melting bath on the substrate.

An essential feature is that the powder is pre-alloyed and contains high amounts of alloying elements, which in this context means that amount of alloying elements of the powder is higher than that of the wire. The amount of the alloying elements should be least 2 % by weight of the powder in order to be effective. The amount of alloying elements of the metal powder as well as the feed of the metal powder and the electrode wire are selected in view of the desired composition of the final coating of the substrate. The powder feeding is usually between 30% and 80% of the total filler metal, i.e. the powder metal and the wire metal. By using gas or water atomised prealloyed powders, a high degree of accuracy of the coating composition can be obtained.

Examples of suitable alloying elements in iron-based powders are Cr, Ni, Mo, Mn, V, Nb, Si, N, C, Co, Ti and W.

An example of a high-alloy iron-based powder which is well suited for surface coating according to the invention is a powder essentially consisting of iron and 0 - 55 % by weight of Cr, 0-50 by weight of Ni, 0-35 by weight of Mo, 0-15 by weight of Mn, 0-17 by weight of V, 0-15 by weight of Nb, 0 -5 by weight of Si, 0 - 0.8 by weight of N, 0 - 8 by weight of C, 0 - 55 by weight of Co, Ti 0 - 15 and 0 - 65 by weight of W.

Preferred amounts of the alloying elements are 12 - 35% by weight of Cr, less than 25 % by weight of Ni, less than 15 % by weight of Mo, 0.05 - 15 % by weight of Mn, 0 - 8 % by weight of V, 0 - 8 % by weight of Nb, 0 - 10.0 % by weight of Si, less than 0.5 % by weight of N and 0.005 - 5 % by weight of C.

More specifically this powder could include 20 - 34 % by weight of Cr, 0 - 18 % by weight of Ni,

0,5 - 8 % by weight of Mo, 0.1 - 5 % by weight of Mn, 0.1 - 2.0 % by weight of V, 0.1 - 2.0 % by weight of Nb, 0.05 - 3.0 % by weight of Si, 0.005 - 0.4 % by weight of N and 0.005 - 0.8 % by weight of C.

5 Another interesting powder composition which is useful according to the invention is an iron-based powder including 0 - 40 % by weight of Co, 7 - 17 % by weight of W, 5 - 15 % by weight of Mo, 0.05 - 2.5 % by weight of Mn, 1 - 6 % by weight of V, 0.05 - 2.5 % by
10 weight of Si, less than 0.40 % by weight of N and 1 - 4.0 % by weight of C.

According to the invention, the main purpose of the melting electrode wire is to provide sufficient heat for melting the metal powder and the substrate surface. A
15 special advantage is that, if combined with different types of metal powders having different alloying elements, the same electrode wire can be used for different types of coatings.

When iron-based, the electrode wire can be unalloyed or low-alloy electrode wire, such as S1 or S2
20 according to DIN 8557. All unalloyed or low-alloy electrode wires including metal cord and flux cord electrodes, i.e. hollow electrodes, can, however, be used according to the invention.

25 By using the above combination of electrode wire and metal powder, it is possible to apply, during the same period of time, a larger amount of coating material on the metal substrate than by using conventional coating methods. Another advantage is that it is possible to
30 obtain the correct surface coating composition with thinner coatings, which means that considerable savings can be made as to the expensive coating material.

According to the invention, the ratio of electrode wire to powder could preferably vary between 2.33 and
35 0.25. Most preferably the ratio is less than 1.5.

The metal substrate can have essentially any form and the coating method according to the invention is only limited by practical considerations. Typical substrates could be low-alloy steels or tool steels, i.e. the chemical composition of the substrate can vary within a wide range.

The flux used in the method according to the invention is preferably a basic unalloyed flux.

The invention is further illustrated by the following examples:

Example 1

Substrate: Roll (diameter 227 mm, length 305 mm)
having a peripheral rotating speed of
21 cm/min.

Power source: 650A, 32.2 V

Twin arc: OK 1220 S2 diameter 2.5 mm available from
ESAB AB, Sweden

Metal powder X: 345-4

Flux: Basic unalloyed.

A final 3 mm coating having the required composition was obtained by applying a magnetic atomised pre-alloyed iron powder having the composition indicated in the table at a rate of 15.0 kg/h and the wire at a rate of 9.5 kg/h, which means that the desired coating was provided at a rate of 24.5 kg/h. The powder was magnetically attached to the outside of electrode wire. The width of the coating was in this case 55 mm. This rate should be compared with conventional coating methods like the SAW method using high-alloy coating materials in the form of strips, wires etc. with no external feeding of metal powder. Due to the high amount of melted substrate material, only approximately 10 kg/h coating material can be delivered to the substrate surface according to the known SAW method and therefore, due to the high dilution, several layers must be pro-

vided before the required surface coating composition is obtained.

The following table 1 shows the composition of the required coating, the wire, the metal powder and the final composition of cuttings obtained from the roll.

Table 1

	Wire composition % by weight	Powder composition % by weight	Final surface coating composition % by weight
C	0.099	0.145	0.129
Si	0.10	0.43	0.34
Mn	1.00	0.48	0.89
S	0.015	0.006	0.013
P		0.013	0.012
Ni		8.82	4.01
Cr		27.35	12.7
Mo		2.03	1.06
V		0.55	0.25
N	0.0037	0.052	0.039
Nb		0.38	0.19

10 Example 2

The method according to Example 1 was repeated with an N alloyed powder. In this example 13.8 kg powder/h and 9.5 kg electrode wire/h were required in order to get the desired coating. The results are listed in the following table 2.

Table 2

	Wire composition % by weight	Powder composition % by weight	Final surface coating composition % by weight
C	0.099	0.020	0.075
Si	0.10	0.41	0.27
Mn	1.00	2.51	1.51
S	0.015	0.008	0.014
P		0.014	0.014
Ni		5.08	2.35
Cr		29.09	12.9
Mo		4.78	2.15
V		0.58	0.27
N	0.0037	0.169	0.079
Nb		0.45	0.18

Example 3

5 The method according to Example 1 was repeated with a magnetic, alloyed powder having the composition according to Table 3. In this example a single arc S2 diameter 4.0 mm was used.

10 8 kg powder/h was direct fed, i.e. magnetically attached to the the outside of the electrode, to the substrate plate and 8.4 kg/h of the powder was forward fed to the substrate plate.

 The wire feed was 8 kg/h for both direct feeding and forward feeding.

15 The results are listed in the following table 3.

Table 3

	Wire composition % by weight	Powder composition % by weight	Final surface coating composition ¹⁾ % by weight	Final surface coating compo- sition ²⁾ % by weight
C	0.10	0.18	0.15	0.16
Si	< 0.15	0.67	0.43	0.41
Mn	1.00	0.44	1.01	1.01
S		0.008	0.005	0.008
P			0.030	0.0288
Ni		7.200	2.137	2.100
Cr		28.90	8.434	8.319
Mo		3.16	0.91	0.89
V		0.38	0.114	0.114

5

¹⁾powder applied on the outside of the electrode²⁾forward feeding

CLAIMS

1. Use of an atomised prealloyed metal powder containing high amounts of alloying elements for feeding separately to a metal substrate or for feeding on the outside of melting, consumable electrode wire(s) or electrode cord(s) in a submerged arc welding (SAW) method.
2. Use of a powder according to claim 1, wherein the powder is an iron-based powder.
3. Use of a powder according to claim 1 or 2, wherein the powder is gas atomised or water atomised.
4. Use according to any one of the claims 1-3 wherein the melting electrode wire or cord essentially consists of an unalloyed or low-alloy metal.
5. Use according to claim 4 wherein the electrode metal is unalloyed or low alloyed iron.
6. Use of a powder according to any one of the claims 1 - 5, wherein the ratio of consumable electrode to powder is between 2.33 and 0.25, preferably less than 1.5.
7. Use according to claim 6 wherein the amount of alloying element in the powder is at least 2 % by weight.
8. Use of a powder according to any one of the claims 1 - 7 wherein the alloying element is selected from the group consisting of Cr, Ni, Mo, Mn, V, Nb, Si, N, C, Co, Ti and W.
9. Use according to claim 8 wherein the amounts, in % by weight, are Cr 0 - 55, Ni 0-50, Mo 0-35, Mn 0-15, V 0-17, Nb 0-15, Si 0 -5, N 0 - 0.8, C 0 - 8, Co 0 - 55, Ti 0 - 15 and W 0 - 65.
10. Use of a powder according to claim 8, wherein the powder essentially consists of iron and 0 - 40 % by weight of Co, 7 - 17 % by weight of W, 5 - 15 % by

weight of Mo, 0.05 - 2.5 % by weight of Mn, 1 - 6% by weight of V, 0.05 - 2.5 % by weight of Si, less than 0.40 % by weight of N and 1 - 4.0 % by weight of C.

11. Use of a powder according to claim 9, wherein
5 the powder consists of an iron-based powder including 12
- 35% by weight of Cr, less than 25 % by weight of Ni,
less than 15 % by weight of Mo, 0.05 - 15 % by weight of
Mn, 0 - 8 % by weight of V, 0 - 8 % by weight of Nb,
0 - 10.0 % by weight of Si, less than 0.5 % by weight of
10 N and 0.005 - 5 % by weight of C.

12. Use of a powder according to claim 11, wherein
the powder consists of an iron-based powder including
20 -34 % by weight of Cr, 0 - 18 % by weight of Ni,
0,5 - 8 % by weight of Mo, 0.1 - 5 % by weight of Mn,
15 0.1 - 2.0 % by weight of V, 0.1 - 2.0 % by weight of Nb,
0.05 - 3.0 % by weight of Si, 0.005 - 0.4 % by weight of
N and 0.005 - 0.8 % by weight of C.

13. Use according to any one of the preceding
claims wherein the powder is magnetic.

20 14. Use of a powder according to any one of the
claims 1 - 13 for surface coating of metal substrates.

15. A method of coating a metal substrate according
to the SAW method based on the use according to the pre-
ceding claims.

INTERNATIONAL SEARCH REPORT

International application No.

PCT/SE 97/01601

A. CLASSIFICATION OF SUBJECT MATTER

IPC6: B23K 9/18, B23K 35/30

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC6: B23K

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

SE,DK,FI,NO classes as above

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EPOQUE; EPODOC, WPI

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 2191471 A (ROBERT K. HOPKINS), 27 February 1940 (27.02.40), page 1, column 2, line 5 - line 39; page 5, column 2, line 10 - page 6, column 1, line 4 --	1-15
X	US 3358115 A (ROMAN F. ARNOLDY), 12 December 1967 (12.12.67), column 5, line 8 - line 28; column 5, line 56 - line 70 --	1-15
A	US 2810063 A (TURNER G. BRASHEAR, JR.), 15 October 1957 (15.10.57) --	1-15

☒ Further documents are listed in the continuation of Box C.☒ See patent family annex.

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Facsimile No. +46 8 666 02 86

Authorized officer

Bertil Dahl

Telephone No. +46 8 782 25 00

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C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	DE 2626824 B (COMBUSTION ENGINEERING, INC.), 20 January 1977 (20.01.77) -- -----	1-15

INTERNATIONAL SEARCH REPORT

Information on patent family members

07/01/98

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Patent document cited in search report			Publication date	Patent family member(s)	Publication date
US	2191471	A	27/02/40	NONE	
US	3358115	A	12/12/67	NONE	
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