


Technical data sheet <small>011121MBA</small>	Cored welding wire HARDFACE 28 3HC-G	 Welding Alloys
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CLASSIFICATION

EN 14700: T Fe14

DESCRIPTION

- Metal cored wire for gas shielded metal arc hardfacing
- High chromium alloy for protective surfacing against abrasion with moderate impact
- Specially designed to achieve wear resistance in one layer

APPLICATIONS

HARDFACE 28 3HC-G is used for hardfacing components undergoing wear by earth, sand and abrasive, including at high temperature and in the presence of moderate corrosion solicitations.

Examples

Gyratory crusher cones and mantles, catalyst pipes and valves, slurry pipes and valve bodies, dredge pump bodies, sand dredge parts, extruder screws, "barmac" crushers, mining and earthmoving equipment, blast furnace bells, brick muller tyres, sugar mill crusher hammers, drag line components, coal pulverisor rolls, coke hammers, cone knives and shredders.

Relief checking is normal and does not affect the properties of the deposit unless there is corrosion. However, it is best limited to two layers unless impact loading is small. Multi-layer deposits are possible in specific applications.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	Fe
2.0	1,7	1.5	28.0	3.0	1.0	Bal.

Microstructure: primary and eutectic chromium carbides in an austenitic matrix

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness:

As welded, 3-Layer deposit on mild steel; 42 HRc

SHIELDING GAS

M21 (Ar + 15 - 25% CO₂), M20 (Ar + 5% < CO₂ ≤ 15%) gas mixtures or C1 (CO₂) according to EN ISO 14175

OPERATING CONDITIONS

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]	Gas flow rate [l/min]
1.6	DC (+)	150 - 300	24 - 28	15 – 20 mm	10 - 20 l/min.

Recovery: 90 %

To achieve a crack free surfacing, it is advised to preheat base metal at 200-300°C.

WELDING POSITIONS

All positions (Up to Φ 1.6 mm)

PACKAGING

Diameter	1.6 mm
	EN ISO 544 – ASME II C SFA-5.2 M
Spool type	BS300
Weight	15 kg

Other packaging and other diameters: please consult us