


Technical data sheet <small>EN141022BG</small>	<p style="text-align: center;">Cored welding Wire</p> <p style="text-align: center;">HARDFACE CHROMEFREE-G</p>	 Welding Alloys
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CLASSIFICATION

EN 14700: T ZFe2

DESCRIPTION

- Tubular wire for gas shielded metal arc hardfacing
- Martensitic weld metal contains finely dispersed hard carbides ensuring an optimal balance between abrasion and impact resistance
- Chromium and Nickel free formulation allowing a safer working environment for the welder
- Abrasion resistance is maintained at service temperatures up to 450°C
- Excellent results according to the normalized test method ASTM G65
- Single or multiple layers weld deposit with excellent welding appeal

APPLICATIONS

HARDFACE CHROMEFREE-G is used for hardfacing components that must combine resistance both to abrasion and to moderate impact

Examples

Bucket teeth, bucket lips, bulldozer blades, scraper blades, conveyor screws, slide plates, gear teeth, crusher hammers, drilling bits, ploughshares, reamers etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Mo	V
0.5	1.2	0.9	2.8	3

Structure: martensite + carbides

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit on mild steel: 50 - 56 HRc

CONDITIONS OF USE

Current type	Shielding gas
DC+	EN ISO 14175
	M21: Ar + 15 to 25% CO ₂
	M12: Ar + 0.5 to 5% CO ₂

Gas flow rate: 15 to 20 l/min

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	100 – 300	250	18 – 33	29	15 – 30	20
1.6	150 – 350	280	22 – 33	29	15 – 30	25

Recovery: 98 %

WELDING POSITIONS

All positions, flat, half up, half down

PACKAGING

Diameter	1.2 – 1.6 mm
Standard packaging	EN ISO 544: BS 300 spool
Weight	15 kg

Other packaging and other diameters: please consult us

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.