

<b>Technical data sheet</b>  <small>011121MBA</small>	<b>Cored welding wire</b> <b>HARDFACE</b> <b>MAXEXTRACT PLUS</b>	 <b>Welding Alloys</b>
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#### CLASSIFICATION

EN 14700: T Fe15

#### DESCRIPTION

- Tubular wire for self-shielded metal arc hardfacing
- High chromium cast iron containing hard complex carbides in a tough austenitic matrix
- Resists extreme conditions of abrasion and impact up to 400°C

#### APPLICATIONS

- HARDFACE MAXEXTRACT PLUS is designed to give a weld deposit of high hardness and extreme wear resistance.
- It is used for hardfacing components undergoing high stress abrasion. Specially developed for "roller arcing" sugar mill rolls during "pre-arc-ing" or whilst crushing. Also suitable for hardfacing crusher hammers and other crushing equipment, augers, conveyor screws and earthmoving components such as bucket lips and ground engaging tools.
- HARDFACE MAXEXTRACT PLUS is also used as a conventional hardfacing wire. It deposits a tough, wear resistant austenitic chromium carbide alloy which combats wear on components subjected to heavy abrasion and moderate to heavy impacts.
- Relief checking is normal.

#### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit on mild steel: 62 - 64 HRc

#### CONDITIONS OF USE

<b>Current type</b>	<b>Protection</b>
DC+	Self-shielded

#### OPERATING CONDITIONS

Diameter [mm]	Intensity [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.6	150 - 350	270	24 - 28	24	25 - 50	25
2.0	200 - 400	300	26 - 30	26	25 - 50	35
2.4	250 - 450	350	26 - 30	28	25 - 50	40
2.8	250 - 450	400	28 - 32	30	25 - 50	40
3.2	250 - 500	450	28 - 32	30	25 - 50	40

Recovery: 90 %

#### WELDING POSITIONS

Flat, half up, half down

#### PACKAGING

Diameter	≤ 2.4 mm		≥ 2.4 mm	
Standard packaging	EN ISO 544: BS 300 spool		B 450 coil	Drum
Weight	15 kg		25 kg	Up to 330 kg

Other packaging and other diameters: please consult us