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| Technical data sheet 011121MBA | <p style="text-align: center;">Coated SMAW Electrode</p> <h1 style="text-align: center;">WA HARDFACE HCNB-E</h1> |  Welding Alloys |
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CLASSIFICATION

EN 14700: E Fe15

DESCRIPTION

- High recovery (230%) basic coated electrode
- Chromium cast iron deposit containing additional carbide-forming elements for increased service life (up to five times)
- Gives a smooth, virtually slag free deposit
- Highly resistant to mineral abrasion with moderate impact
- Relief cracks are normal

APPLICATIONS

Endless screws, mixer paddles, pump bodies for abrasive materials and cement, excavator bucket teeth, screws, moulds and dies for brick making

TYPICAL ALL-WELD METAL ANALYSIS [%]

| C | Si | Cr | Nb | Others | Fe |
|---|----|----|-----|--------|------|
| 5 | 1 | 28 | 2.7 | 3 | Bal. |

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: ~64 HRC, obtained in one layer

OPERATING CONDITIONS

| | | |
|----------------------|-----------|-----------|
| Electrode Ø x L [mm] | 3.2 x 350 | 4.0 x 450 |
| Current [A] | 140 | 180 |
| = + | ~ 70V | |

Re-drying, if necessary, at 250°C for 1 hour. Maintain a short arc and hold the electrode nearly vertical. To minimise dilution with the base metal, select the lowest current that gives a stable arc and weave only slightly. Weld single layers, maximum two layers.

WELDING POSITIONS

EN ISO 6947: PA
ASME IX: 1G

PACKAGING

| | | |
|----------------------|-----------|-----------|
| Electrode Ø x L [mm] | 3.2 x 350 | 4.0 x 450 |
| Weight/box [kg] | 5 | 6.5 |

Other packaging and other sizes: 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.