

**Technical data sheet**

011121MBA

Cored welding wire  
**HARDFACE B-O**

**CLASSIFICATION**

EN 14700: T Fe1

**DESCRIPTION**

- Tubular wire for self shielded metal arc hardfacing
- Low alloy steel deposit, suitable as an underlayer
- Ideally suited to heavy build-up work in multiple layers
- The weld deposit is machinable and crack free

**APPLICATIONS**

Building up of all components exposed to metal-metal wear in direct contact with a mating carbon steel or low alloy steel surface.

**Examples**

Crane wheels, trolley wheels, locomotive wheels, gears, steel shafts, idlers, rollers.  
Repair, rebuilding and under-layers on forge tooling

**TYPICAL ALL-WELD METAL ANALYSIS**

C	Mn	Si	Cr
0.1	1.5	0.4	1.0

Structure: bainite

**TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES**

Hardness – 3-layer deposit on mild steel: 260 HB

**CONDITIONS OF USE**

Current type	Protection
DC+	Self-shielded

**OPERATING CONDITIONS**

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	100 - 300	250	21 - 35	28	25 - 50	25
1.6	150 - 350	270	24 - 35	28	25 - 50	25
2.0	200 - 400	300	26 - 35	28	25 - 50	35
2.4	250 - 450	350	26 - 35	28	25 - 50	40
2.8	250 - 450	400	28 - 35	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

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.