

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

EN 14700: T Fe8

DESCRIPTION

- Cored wire for metal gas arc hardfacing
- Martensitic-ferritic stainless steel deposit
- Designed to resist metal-to-metal wear, corrosion and thermal fatigue fire cracking

APPLICATIONS

HARDFACE D-G is used for surfacing continuous casting rolls

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	V	W	Co	Fe
0.25	1	0.4	12.5	1.5	2.1	1	2	Bal.

Structure: martensite + ferrite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit on mild steel: 48 - 52 HRC

CONDITIONS OF USE

Current type	Shielding gas	
DC+	EN ISO 14175	M12: Ar + 0.5 – 5 % O ₂
		M13: Ar + 0.5 - 3% O ₂
		M21: Ar + 15 – 25 % CO ₂

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.6	130 - 350	250	16 - 32	25	12 - 25	15
2.0	200 – 400	300	25 - 32	30	12 - 25	20
2.4	250 - 450	350	25 - 32	30	12 - 25	20

Recovery: 95 %

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.