


Technical data sheet <small>011121MBA</small>	Cored Welding Wire HARDFACE P 6000-O	 Welding Alloys
---	---	---

CLASSIFICATION

EN 14700: T Fe16

DESCRIPTION

- Tubular wire for self-shielded metal arc hardfacing
- High chromium cast iron with alloying additions giving a high concentration of complex carbides in a tough austenitic matrix
- Resists extreme conditions of abrasion and impact up to 600°C

APPLICATIONS

HARDFACE P 6000-O is designed to give a weld deposit of particularly high hardness and wear resistance on account of the dispersion of hard complex carbides it contains. This gives superior performance compared to standard chromium cast irons. Optimum properties are reached in two or three layers. Relief checking is normal and necessary.

Examples

Wear protection of parts for the brick & tile industries, catalyst pipes and valves, slurry pipes and valve bodies, dredge pump bodies, sand dredge parts, extruder screws, crushers, mining and earthmoving equipment, drag line components etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	Nb	W	B
5,6	0,2	2	29,5	0,5	2,1	0,4	0,4

Structure: hard primary and secondary complex carbides in a tough austenitic-martensitic matrix.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit on mild steel: 60 - 65 HRc

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
1.6	160 - 320	250	24 - 30	28	20 - 30	25
2.4	250 - 450	350	26 - 32	30	25 - 40	30
2.8	250 - 450	400	26 - 32	30	25 - 40	30

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.