

**Technical
data sheet**

011121MBA

Cored welding wire

HARDFACE P-S**CLASSIFICATION**

EN 14700: T Fe1

DESCRIPTION

- Low-alloy tubular wire for submerged arc hardfacing
- The deposit is mixed bainitic/martensitic with machinability and good cracking, impact and abrasion resistance
- Especially applicable in 2-3 layers for wear resistance
- Welding under a flux blanket eliminates the emission of toxic fumes, particularly hexavalent chromium

APPLICATIONS

HARDFACE P-S is used for rebuilding and hardfacing of items undergoing metal-to-metal friction with moderate abrasion.

Examples

Build-up of earthmoving equipment such as tractor rollers, idlers, chains, excavator pads, electric shovel track carrier rolls, steel shafts, crane wheels, steel mill rolls, mine car wheels, dredge pins, dredge links, mixer parts, rail car couplings, steel mill roll couplings.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr
0.2	2	0.8	3

Structure: martensite + bainite

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES

Hardness of a 3-layer deposit on mild steel: 400 HB

FLUX DESCRIPTION

	WA FLUX 325	WA FLUX 385	WA FLUX 415	WA ULTRAFLUX
EN ISO 14174 class	S A AB 1 65	S A AF 2 64	S A FB 1 55	S A FB 1 55

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
2.4	200 - 450	350	26 - 30	30	25 - 40	30
2.8	250 - 550	400	28 - 32	30	25 - 40	30
3.2	300 - 650	500	28 - 32	30	25 - 40	30

Recovery: 95 %

Current type/polarity: DC+

WELDING POSITIONS

Flat

PACKAGING

Diameter	≥ 2.4 mm	
Standard packaging	B 450 coil	Drum
Weight	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.