


Technical data sheet <small>011121MBA</small>	Coated SMAW Electrode WA HARDFACE L-E	 Welding Alloys®
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CLASSIFICATION

EN 14700: E Fe8

DESCRIPTION

- Basic coated electrode for hardfacing
- Low-alloy hard martensitic deposit, highly resistant to impact, abrasion and compressive stresses
- Quiet and stable arc, easy slag removal
- Machinable only by grinding

APPLICATIONS

Hardfacing and repair of parts subjected to the combined action of compression, impact and/or abrasive wear.

Examples

Press tooling, gear teeth, cable drums, dredger buckets, crusher parts, cutting tools, steel mill rolls, conveyor chutes, grizzly bars etc.

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Cr	Fe
0.5	0.6	2.5	9.5	Bal.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness

As welded all-weld metal: 58 HRc
 Single layer on manganese steel: ~22 HRc
 Two layers on manganese steel: ~40 HRc
 Single layer on mild steel: ~50 HRc
 Two layers on mild steel: ~55 HRc
 Machinability: by grinding

OPERATING CONDITIONS

Electrode ØxL [mm]	2.5 x 350	3.2 x 350	4.0 x 450	5.0 x 450
Current [A]	60 - 90	90 - 120	110 - 160	170 - 210
= +	~ 70V			

Recovery: 120 %

Electrodes may be dried at 300°C for two hours, if necessary. Preheating is not required on mild and medium carbon steels. Heavy parts and low alloyed, high carbon tool steels need to be preheated to 250 - 400°C, depending on their composition and thickness. Maintain the temperature during welding. Cool slowly in still air after surfacing. If more than 3 layers are needed, apply softer electrodes for rebuilding.

WELDING POSITIONS

EN ISO 6947: PA, PC, PF, PE
 ASME IX: 1G, 2G, 3G, 4G

PACKAGING

Electrode ØxL [mm]	2.5 x 350	3.2 x 350	4.0 x 450	5.0 x 450
Weight/box [kg]	5	5	6.5	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.