

# HARDFACE 19 9 6-S

For Welding Professionals



**Best work hardening austenitic stainless steel**



HARDFACE 19 9 6-S is a metal cored wire for submerged arc welding jobs, providing a work hardening austenitic 19Cr-9Ni-6Mn deposit.

It is the ideal solution to maximise the deposition rate (by 35% minimum) when compared to an equivalent solid wire.

When using HARDFACE 19 9 6-S, the travel speed can be increased and the heat input reduced (by up to 30%), therefore having a positive impact on the properties of the polymer filler block.

This wire (in combination with our WAF 415 flux) can be used for both preventative and repair weld overlays.

## Why choose this solution?

- The easiest solution to improve performance of submerged arc welding
- Perfectly suited for repairing hard-to-weld steels such as grooved rails
- Overalloyed manganese content helps to improve high pressure and metal-to-metal wear resistance, compared to the equivalent 307 solid wire
- Lower risk of lack of fusion and spalling
- Attractive weld appearance with a clean surface and sound deposit



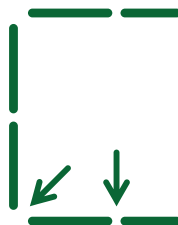
## Product Details

**Classification:** ISO 14174: S A FB 1 55 (flux WAF 415)  
EN 14700: T Fe10

**Available Diameter:** 2.4 mm, 2.8 mm, 3.2 mm

**Hardness:** 200 HB (as welded, three-layer deposit)  
47 HRC (work hardened, three-layer deposit)

**Welding Positions:**



[contactus@welding-alloys.com](mailto:contactus@welding-alloys.com)  
[www.welding-alloys.com](http://www.welding-alloys.com)

