

**Technical
data sheet**

011121MBA

Cored welding Wire

HARDFACE 19 9 6-S**CLASSIFICATION**

EN 14700: T Fe10

DESCRIPTION

- Tubular wire for submerged arc hardfacing
- Crack resistant austenitic stainless weld deposit
- Good impact, cavitation and corrosion resistance
- The weld deposit work hardens to different degrees depending on amount of impact
- Resists scaling up to 850°C, good resistance to thermal shocks

APPLICATIONS

- HARDFACE 19 9 6-S is mainly used to rebuild components exposed to high impact and corrosion.
- Buffer layer before hardfacing

Examples

Steel mill rolls, metallurgical plant guides, tram and train rails and fittings, high speed forming rolls

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni
0.10	6.00	0.50	19.0	9.00

Structure: austenite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit:

As welded: 200 HB

Work hardened: 47 HRC

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 - 50	30
2.8	250 - 500	400	28 - 32	30	25 - 50	30
3.2	250 - 550	450	28 - 32	30	25 - 50	30
4.0	300 - 600	500	28 - 32	30	25 - 50	30

Recovery : 95%

Current type/polarity: DC+

WELDING POSITIONS

Flat

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.