Technical data sheet 011121MBA	Cored welding wire # HARDFACE 600-S	Welding Alloys

CLASSIFICATION

EN 14700: TFe2

DESCRIPTION

- Tubular wire for submerged arc hardfacing
- Martensitic deposit
- Welding under a flux blanket eliminates the emission of toxic fumes, particularly hexavalent chromium

APPLICATIONS

Hardface 600-S is used for hardsurfacing components that must combine resistance both to abrasion and to moderate impact

Examples

Bulldozer blades, crusher jaws, chutes, slide plates, crusher hammers etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo
0.5	1.2	0.7	6.0	0.5

Structure: martensite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness (3-layer deposit as welded): 600 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 - 60	30
2.8	250 - 550	400	28 - 32	30	25 - 60	30
3.2	300 - 650	500	28 - 32	30	25 - 60	30

Recovery: 95 %

Current type/polarity: DC+

WELDING POSITIONS

EN ISO 6947: PA, PB.

ASME IX: 1G, 1F, 2F

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