

Technical data sheet <small>011121MBA</small>	Cored welding wire HARDFACE 751	 Welding Alloys
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CLASSIFICATION

EN 14700: T Fe16

DESCRIPTION

- Cored wire for self-shielded metal arc hardfacing
- The deposit contains hard complex carbides in a tough matrix and performs exceptionally well in both fine and coarse abrasion

APPLICATIONS

HARDFACE 751 is used for hardfacing components undergoing heavy wear by earth, sand or other abrasives. Relief checking is normal.

Examples

Sand and earthmoving equipment such as buckets and teeth, railway ballast tampers, dredge buckets and lips, dragline buckets, coke hammers, rippers, sizing screens, crushing equipment, brick industry components, Muller tyres, catalyst lift pipes, pump impellers, fan blades, rockwool rolls, wear plates operating at high temperature in the steelmaking industry.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Nb	W
5.0	1.0	1.5	19	6.3	5.8

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit on mild steel: 60 – 62 HRc

CONDITIONS OF USE

Current type	Protection
DC+	Self-shielded

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
2.4	250 - 450	350	26 - 30	28	25 - 50	40
2.8	250 - 450	400	28 - 32	30	25 - 50	40
3.2	250 - 500	450	28 - 32	30	25 - 50	40

Recovery: 90 %

WELDING POSITIONS

Flat, half up, half down

PACKAGING

Diameter	≥ 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