

Technical data sheet

150222JMBA

Cored welding wire

HARDFACE AP-O**CLASSIFICATION**

EN 14700: T Fe9

DESCRIPTION

- Flux cored wire for self-shielded metal arc hardfacing
- Austenitic deposit with excellent work hardening properties
- Highly resistant to impact and high pressures

APPLICATIONS

HARDFACE AP-O produces an austenitic, non-magnetic weld deposit which has excellent work hardening properties. The degree of work hardening is dependent on the amount of impact on the rebuilt component. It is used for rebuilding components exposed to severe impacts or heavy loads and can be welded on ferritic and austenitic steels including "Hadfield" manganese steel. It forms an excellent buffer layer prior to hardfacing with high chromium cast iron. The deposit can be multi-layered without limit.

Examples

Railway frogs and crossings, hydraulic press pistons, crushing equipment subjected to heavy shock, hammers, dredge pumps and all components where a work-hardening deposit is desirable.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Fe
0.4	14	0.6	14.5	Bal.

Structure: austenite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit

As welded: 200 – 240 HB / 20 – 25 HRc

Work hardened: 45 – 55 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
1.6	150 - 350	270	24 - 35	28	25 - 50	25

Recovery: 90%

WELDING POSITIONS

Flat, half up, half down

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.