

Technical data sheet <small>011121MBA</small>	Cored welding wire HARDFACE AR-G	
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CLASSIFICATION

EN 14700: T Fe4

DESCRIPTION

- Tubular wire for gas shielded metal arc hardfacing giving a tough high-speed steel deposit
- Exceptional wear resistance in cold cutting operations
- Keeps its properties to 600°C.
- The hardness may be increased to around 65 HRC by tempering

APPLICATIONS

HARDFACE AR-G is used for hardfacing components subject to metal-to-metal wear under conditions of moderate impact.

Examples

Machining tools, cold shearing blades, milling cutters, knives and wire guides

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	V	W
1.1	0.5	0.5	4.9	7.5	1.1	2.3

Structure: martensite + carbides

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit on mild steel: 57 - 63 HRc.

A heat treatment at 530°C for 4 to 8 hours increases the hardness by 3 – 4 HRc.

CONDITIONS OF USE

Current type	Shielding gas
DC+	M12: Ar + 0.5 to 5% CO ₂
	M13: Ar + 0.5 to 3% O ₂
	M20: Ar + 5 to 15% CO ₂
	M21: Ar + 15 to 25% CO ₂

Gas flow rate: 15 to 20 l/min

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	100 – 300	220	18 – 33	28	15 – 30	20
1.6	150 – 350	280	22 – 33	28	15 – 30	25

Recovery: 95 %

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.