

<b>Technical data sheet</b>  011121MBA	Cored welding wire  <b>HARDFACE ARM7-G</b>	 <b>Welding Alloys</b>
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#### DESCRIPTION

- Tubular wire for gas shielded metal arc hardfacing giving a tough high speed tool steel deposit
- Excellent wear resistance due to the presence of small primary carbides
- Excellent resistance to softening at elevated temperatures

#### APPLICATIONS

HARDFACE ARM7-G is used for hardfacing components subject to abrasive wear and moderate impact

#### Examples:

Tillage tools, shearing blades, high speed cutting tools

#### TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	V	W	Nb	B
<1.0	<0.75	<1.0	<5.0	<5.0	<2.0	<5.0	<5.0	<0.5

#### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit on mild steel: 62-65 HRC

#### CONDITIONS OF USE

Current type	Shielding gas
DC+	EN ISO 14175
	M12: Ar + 0.5 – 5 % CO <sub>2</sub>
	M13: Ar + 0.5 – 3% O <sub>2</sub>
	M21: Ar + 15 – 25 % CO <sub>2</sub>

Gas flow rate: 15 – 20 l/min

#### OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out	
	Range	Optimum	Range	Optimum	Range	Optimum
1.6mm	200 - 300	250	20 - 26	25	15mm – 30mm	25mm

#### 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