

<b>Technical data sheet</b>  <small>011121MBA</small>	<b>Cored Welding wire</b>  <b>HARDFACE B-G</b>	 <b>Welding Alloys</b>
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### CLASSIFICATION

EN 14700: T Fe1

### DESCRIPTION

- Tubular wire for gas shielded metal arc hardfacing
- Low alloys and crack-resistant steel deposit

### APPLICATIONS

HARDFACE B-G is ideally suited for heavy multi-layer build up work. Weld deposit is machinable.

#### Examples

Build up of all components exposed to metal-metal wear. Components in direct contact with a mating carbon steel or low alloy steel surface.

Ideal for components such as crane wheels, trolley wheels, locomotive wheels, gears, steel shafts, idlers, rollers and any components subject to metal-metal wear.

### TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Fe
0.10	1.50	0.40	1.00	Bal.

Structure: bainite

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit on mild steel: 260 HB

### CONDITIONS OF USE

Current type	Shielding gas	
DC+	EN ISO 14175	M12: Ar + 0.5 to 5% CO <sub>2</sub>
		M13: Ar + 0.5 to 3% O <sub>2</sub>
		M20: Ar + 5 to 25% CO <sub>2</sub>
		M21: Ar + 15 to 25% CO <sub>2</sub>

Gas flow rate: 15 to 20 l/min

### OPERATING CONDITIONS

Diameter [mm]	Amperage [A]	Voltage [V]	Stick-out [mm]
1.2	100 - 300	24 - 32	12 – 25
1.6	150 - 300	24 – 32	12 – 25
2.0	200 - 400	24 – 32	12 – 30
2.4	250 - 450	24 - 32	12 – 30

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.