

**Technical data sheet**

011121MBA

Cored welding Wire

**HARDFACE BN-O****CLASSIFICATION**

EN 14700: T ZFe13

**DESCRIPTION**

- Tubular wire for self-shielded metal arc hardfacing
- The deposit contains boron carbides which give very good abrasion resistance combined with moderate impact resistance
- Recommended for single layer application

**APPLICATIONS**

HARDFACE BN-O is used for hardfacing components undergoing wear by earth, sand and abrasives in the agricultural, quarrying, mining, and public works fields

**Examples**

Mixer shafts, impellers, buckets, shovels, transport screws and crushers for the concrete industry, ...

**TYPICAL ALL-WELD METAL ANALYSIS**

C	Mn	Si	Ni	B	Ti	Fe
0.5	2.0	1.3	2.0	4.5	0.3	Bal.

Structure: hard borides in a eutectic matrix.

**TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES**

Hardness (single-layer deposit on mild steel): 60 - 65 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
1.2	100 - 250	170	21 - 28	26	20 - 30	20
1.6	160 - 320	250	24 - 30	28	20 - 30	25
2.0	200 - 400	260	25 - 32	29	25 - 40	30
2.4	250 - 450	350	26 - 32	30	25 - 40	30
2.8	250 - 450	400	26 - 32	30	25 - 40	30
3.2	250 - 550	480	26 - 32	31	25 - 40	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.