Technical data sheet 011121MBA	Cored welding Wire # HARDFACE BNC-O	Welding Alloys

CLASSIFICATION

EN 14700: T ZFe16

DESCRIPTION

- Tubular wire for self-shielded metal arc hardfacing
- Alloy designed for extreme resistance to high stress grinding abrasion with moderate impact
- The abrasion resistance and hardness are achieved in one layer thus allowing interesting cost saving
- Suitable for service temperatures up to 650°C

APPLICATIONS

The deposit resists abrasion by small particles under high restraint or erosion in gaseous media.

Examples

Screw conveyors, blast furnace bells and screens operating at high temperatures, ceramic augers, sinter breakers, extractor fans, etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Nb	B
2.5	2	0.6	11.5	5	2.2

Structure: chromium and niobium carbides and borides in a hard austenite-martensite matrix

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: Single-layer deposit on mild steel: 64 - 68 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

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.