

<b>Technical data sheet</b>  <small>011121MBA</small>	<b>Cored welding wire</b>  <b>HARDFACE BUF-O</b>	
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### CLASSIFICATION

EN 14700: T Fe1

### DESCRIPTION

- Tubular wire for self-shielded metal arc hardfacing
- Surfacing or rebuilding parts subjected to high compression stresses and high impact

### APPLICATIONS

HARDFACE BUF-O is used as buffer layer on ferritic steels before hardsurfacing with wires providing higher abrasion resistance or for rebuilding

#### Examples

Gear teeth, conveyor chains, wheels for rolling bridges, shafts, bearing tracks...

### TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Ni	Mo	Al
0.15	1.1	0.4	1.8	0.3	1.7

Structure: bainite

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit

As welded: 250 HB

### CONDITIONS OF USE

Current type	Protection
DC+	Self-shielded

### OPERATING CONDITIONS

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
2.4	180 - 350	280	24 - 32	28	25 - 50	30
2.8	200 - 400	350	24 - 33	29	25 - 50	30
3.2	300 - 450	400	27 - 35	30	25 - 50	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.