

**Technical
data sheet**

050122MBA

Cored welding Wire

HARDFACE CN-S**CLASSIFICATION**

EN 14700: T Fe15

DESCRIPTION

- Tubular wire for submerged-arc hardfacing
- High chromium cast iron deposit containing hard complex carbides in a tough austenitic matrix
- Resists extreme conditions of abrasion and moderate impact up to 300°C
- Welding under a flux blanket eliminates the emission of toxic fumes, particularly hexavalent chromium

APPLICATIONS

HARDFACE CN-S is designed to give a weld deposit of high hardness and wear resistance. It is used for hardfacing components undergoing heavy wear by earth, sand or other abrasives. Relief checking is normal.

Examples

Sand and earthmoving equipment such as buckets and teeth, railway ballast tampers, dredge buckets and lips, dragline buckets, coke hammers, rippers, sizing screens, crushing equipment, brick industry components, Muller tyres, catalyst lift pipes, pump impellers, fan blades, rockwool rolls, wear plates operating at high temperatures in the steelmaking industry.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Nb
5	0.5	1	22	7

Structure: chromium and niobium carbides in an austenitic matrix. Niobium carbides increase abrasion and impact resistance compared to classical high chromium cast irons.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit on mild steel: 62 - 64 HRC

FLUX DESCRIPTION

	WA FLUX 325	WA FLUX 385	WA FLUX 415	WA ULTRAFLUX
EN ISO 14174 class	S A AB 1 65	S A AF 2 64	S A FB 1 55	S A FB 1 55

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
2.8	250 - 550	400	28 - 32	30	25 - 60	30
3.2	300 - 650	500	28 - 32	30	25 - 60	30

Recovery: 95 %

Current type/polarity: DC+

WELDING POSITIONS

Flat

PACKAGING

Diameter	≥ 2.4 mm	
Standard packaging	B 450 coil	Drum
Weight	25 kg	Up to 330 kg

Other packaging and other diameters: please consult us

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