

Technical data sheet <small>011121MBA</small>	Cored welding wire HARDFACE CNB-O	 Welding Alloys
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CLASSIFICATION

EN 14700: T Fe15

DESCRIPTION

- Tubular wire for self-shielded metal arc hardfacing
- High chromium-niobium-boron cast iron for hardfacing components subject to high stress and gouging abrasion
- High hardness and abrasion resistance are achieved in one layer

APPLICATIONS

HARDFACE CNB-O is designed to give a weld deposit of particularly high hardness and wear resistance on account of the dispersion of carbides it contains. This gives superior performance compared to standard chromium cast irons. Relief checking is normal.

Examples

Shovel bucket teeth and lips, bulldozer blades working in sand, screens in the coal industry, brick and clay mill augers, groundnut oil expeller screws, wear plates, etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Nb	B
5.2	0.5	1	22	7	0.9

Structure: chromium and niobium carbides and borides 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: 65 HRc

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
1.6	150 - 350	270	24 - 35	28	25 - 50	25
2.4	250 - 450	350	26 - 35	28	25 - 50	40
2.8	250 - 450	400	28 - 35	30	25 - 50	40

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.