

Technical data sheet

011121MBA

Cored welding wire

HARDFACE CV-O**CLASSIFICATION**

EN 14700: T Fe16

DESCRIPTION

- Tubular wire for self-shielded metal arc hardfacing
- High chromium cast iron for hardfacing components subject to extremely severe abrasive wear and moderate impact up to 600°C

APPLICATIONS

HARDFACE CV-O is used for hardfacing components undergoing high stress abrasion and solid erosion at service temperatures up to 600°C.
Relief checking is normal.

Examples

Used for ore crushing, riddling, blast furnace hoppers and throats, ovens, etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	Nb	V	W
5.2	0.2	1.3	21	3.3	6.2	0.4	1

Structure: austenitic matrix with hexagonal primary carbides, eutectic carbides and nodular niobium carbides.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit on mild steel: 64 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 - 300	160	24 - 30	28	25 - 50	25
1.6	150 - 350	250	24 - 30	28	25 - 50	25
2.0	200 - 400	300	26 - 30	28	25 - 50	35
2.4	250 - 450	350	26 - 30	28	25 - 50	40
2.8	250 - 450	400	28 - 32	30	25 - 50	40
3.2	250 - 500	450	28 - 32	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.