


Technical data sheet <small>011121MBA</small>	Cored welding wire HARDFACE DUALHARD C-S	 Welding Alloys
---	---	---

CLASSIFICATION

EN 14700: T Fe3

DESCRIPTION

- Tubular wire for submerged arc cladding
- Ferritic-martensitic alloy susceptible to secondary hardening by heat treatment
- High hardness
- Resistant to metal to metal wear at high temperatures and to thermal fatigue

APPLICATIONS

Rebuilding of rolls for hot strip mills, specifically pinch and wrapper rolls

TYPICAL ALL-WELD METAL ANALYSIS

C	Si	Mn	Cr	Mo	V	W
0.35	0.8	1.4	6.5	1.5	1.5	1

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness (3-layer deposit on mild steel):

As welded: 55 – 60 HRc

After secondary hardening at 500°C / 6 hours: 57 – 62 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
2.4	200 - 450	350	26 - 30	30	25 - 40	30
2.8	250 - 550	400	28 - 32	30	25 - 40	30
3.2	300 - 650	500	28 - 32	30	25 - 40	30

Recovery : 95 %

Current type/polarity: DC+

Preheat prior to welding and slow cooling afterwards are advisable. Stress relief after welding may also be necessary.

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

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.