

Technical data sheet <small>011121MBA</small>	Cored welding wire HARDFACE HC-S	
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CLASSIFICATION

EN 14700: T Fe15

DESCRIPTION

- Tubular wire for submerged-arc hardfacing
- High chromium cast iron deposit containing a high proportion of hard primary chromium carbides in a tough austenitic matrix
- The deposit is suitable for hardfacing components subject to extremely severe abrasive wear and moderate impact
- Welding under a flux blanket eliminates the emission of toxic fumes, particularly hexavalent chromium

APPLICATIONS

HARDFACE HC-S is used for hardfacing components undergoing wear by earth, sand and abrasives.

Examples

Gyratory crusher cones and mantles, catalyst pipes and valves, slurry pipes and valve bodies, dredge pump bodies, sand dredge parts, extruder screws, "barmac" crushers, mining and earthmoving equipment, blast furnace bells, brick muller tyres, crusher hammers and rolls, riddle plates, wear plates, drag line components, screw conveyors for cement, cone knives and shredders.

Relief checking is normal and does not affect the properties of the deposit. However, it is best limited to two layers unless impact loading is small. Multi-layer deposits are possible in specific applications.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr
5	1.5	1.5	27

Structure: primary carbides and eutectic carbides of the M_7C_3 type in an austenitic matrix.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit on mild steel: 58 - 63 HRc

FFLUX 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

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.