

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

EN 14700: T Fe15

DESCRIPTION

- High chromium cast iron for hardfacing components subject to extremely severe abrasive wear and moderate impact
- The deposit contains a high proportion of hard primary chromium carbides in a tough austenitic matrix
- Excellent weldability

APPLICATIONS

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

Examples

Slurry pipes and valve bodies, catalyst pipes and valves, dredge pump bodies, sand dredge parts, extruder screws, "barmac" crushers, mining and earthmoving equipment, blast furnace bells, brick muller tyres, sugar mill crusher hammers, drag line components, coal pulveriser rolls, coke hammers, cone knives and shredders, gyratory crusher cones and mantles,

Relief checking is normal and best limited to two layers unless impact loading is small. Can be multi-layered in specific applications.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr
5	1	1	28

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: 60 – 62 HRc

CONDITIONS OF USE

Current type	Protection
DC+	Self-shielded

OPERATING CONDITIONS

Diameter	Amperage [A]		Voltage [V]		Stick-out	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	100 - 300	250	21 - 35	28	25 - 50	25
1.6	150 - 350	270	24 - 35	28	25 - 50	25
2.0	200 - 400	300	26 - 35	28	25 - 50	35
2.4	250 - 450	350	26 - 35	28	25 - 50	40
2.8	250 - 450	400	28 - 35	30	25 - 50	40
3.2	250 - 500	450	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	Spool EN ISO 544: BS 300	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.