

Technical data sheet

011121MBA

Cored welding wire

HARDFACE LC-O**CLASSIFICATION**

EN 14700: T ZFe14

DESCRIPTION

- Tubular wire for self shielded metal arc hardfacing
- The deposit contains a high proportion of hard primary chromium carbides in a tough austenitic matrix
- Under conditions of moderate to heavy impact, the weld deposit work hardens

APPLICATIONS

HARDFACE LC-O is used for hardfacing components subject to abrasion and moderate to heavy impact.

Examples

Typical applications include multi-layer hardfacing on heavy mining and earth-moving equipment, gyratory crusher cones and mantles, crusher hammers, shredder bars.

HARDFACE LC-O is also suitable for overlays on Hadfield (12% Mn) steels. However, specialist consideration must be given to the service conditions of the mantle, condition of the worn component and techniques used during welding. Please contact us for specialist advice.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	Cu
2.90	1.60	1.20	8.10	1.10	0.50

Structure: hard primary chromium carbides in a tough austenitic matrix

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit on mild steel:

As-welded: 50 HRc
Work hardened: 55 HRc

CONDITIONS OF USE

Current type	Shielding
DC+	Self-shielded

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	100 - 300	250	21 - 35	28	12 - 25	20
1.6	150 - 300	270	24 - 35	28	15 - 25	25
2.0	200 - 400	300	26 - 35	28	20 - 50	30
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.