

<b>Technical data sheet</b>  <small>011121MBA</small>	<b>Cored welding wire</b>  <b>HARDFACE LP-G</b>	 <b>Welding Alloys</b>
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### CLASSIFICATION

EN 14700: T Fe8

### DESCRIPTION

- All positional cored wire for gas shielded metal arc hardfacing
- Martensitic weld metal with good abrasion and impact resistance
- Self-tempering deposit for hardfacing
- Especially applicable in 2-3 layers for wear resistance
- The weld deposit is just machinable with special tools

### APPLICATIONS

HARDFACE LP-G is used when good resistance to abrasion and impact in dry or wet environments is required.

#### Examples

Bucket teeth, lips and undersides, cutting edges, steel mill rolls, cable drums, sand dredge equipment, dragline buckets, conveyor chutes, grizzly bars

### TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Others	Fe
0.5	1.8	1.3	7.5	+	Bal.

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-Layer deposit

As welded: 55 - 60 HRc

### CONDITIONS OF USE

Current type	Shielding gas	
DC+	EN ISO 14175	M21: Ar + 15 – 25 % CO <sub>2</sub>

### OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	100 - 280	220	18 – 30	27	15 – 25	20
1.6	150 - 350	300	22 - 30	30	15 - 25	20

Recovery: 95 %

### WELDING POSITIONS

All Positions

### 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.