

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

EN 14700: T Fe15

### DESCRIPTION

- Tubular wire for self-shielded metal 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

### APPLICATIONS

HARDFACE MAXEXTRACT is used for hardfacing components undergoing wear by earth, sand and abrasives.

#### *Example in the Sugar industry*

Tear drops and spatters on the grinding roll

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit on mild steel: 58 – 64 HRC

### CONDITIONS OF USE

<b>Current type</b>	<b>Protection</b>
DC+	Self-shielded

### OPERATING CONDITIONS

Diameter [mm]	Wire feed speed [m/min]		Intensity [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum	Range	Optimum
1.2	3.7 - 18.0	9.0	100 - 250	170	21 - 28	26	10 - 25	20
1.6	1.8 - 12.0	8.0	160 - 320	250	24 - 30	28	10 - 25	25
2.0	2.0 - 8.0	6.0	200 - 400	260	25 - 32	29	20 - 30	30
2.4	2.0 - 8.0	5.0	250 - 450	350	26 - 32	30	25 - 30	30
2.8	1.5 - 7.0	4.5	250 - 450	400	26 - 32	30	25 - 30	30
3.2	1.5 - 6.0	4.0	250 - 550	480	26 - 32	31	25 - 30	30

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