

Technical data sheet <small>011121MBA</small>	Cored Welding Wire HARDFACE MC-O	 Welding Alloys
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CLASSIFICATION

EN 14700: T ZFe14

DESCRIPTION

- Tubular wire for self-shielded metal arc hardfacing
- Offers an optimised compromise for resistance to simultaneous abrasive wear and impact

APPLICATIONS

HARDFACE MC-O is used for hardfacing components undergoing abrasion and impact

Examples

Crusher parts for relatively soft materials, brick industry components, bucket lips, garbage crusher hammers, shredders, conveyor screws, augers, wear bars etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr
3	1.5	1.5	15

Structure: eutectic carbides in an austenitic matrix

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit on mild steel: 46-50 HRc

CONDITIONS OF USE

Current type	Protection
DC+	Self-shielded

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	100 - 250	170	21 - 28	26	20 - 30	20
1.6	160 - 320	250	24 - 30	28	20 - 30	25
2.0	200 - 400	260	25 - 32	29	25 - 40	30
2.4	250 - 450	350	26 - 32	30	25 - 40	30
2.8	250 - 450	400	26 - 32	30	25 - 40	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

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.