


Technical data sheet <small>011121MBA</small>	Cored welding wire HARDFACE NM14-O	 Welding Alloys
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CLASSIFICATION

EN 14700: T Fe9

DESCRIPTION

- Flux cored wire for self-shielded metal-arc hardfacing
- Manganese steel austenitic deposit which resists combined frictional wear and impacts
- The deposit has the same colour as the base material

APPLICATIONS

- Rebuilding 14% manganese steel castings
- Under-layer for 14% manganese steels before hardfacing

Examples

Crusher components, hammers, beaters and anything exposed to heavy forces and crushing. Not to be used on ferritic steels.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si
1	14	0.5

Structure: austenite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness (3-layer deposit):

As welded: 200 HB

Work hardened: 46 HRC

CONDITIONS OF USE

Current type	Protection
DC+	Self-shielded

Manganese steels must be welded as cold as possible.

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	110 - 300	220	22 - 30	28	25 - 50	30
1.6	150 - 350	270	24 - 30	28	25 - 50	30
2.0	200 - 400	300	26 - 30	28	25 - 50	35
2.4	250 - 450	350	26 - 30	28	25 - 50	40
2.8	300 - 550	400	28 - 32	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.