

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

EN 14700: T Fe1

### DESCRIPTION

- Metal cored tubular wire for gas shielded metal arc hardfacing
- Low alloy steel deposit
- Ideally suited to heavy build-up work in multiple layers
- The weld deposit is machinable and crack free

### APPLICATIONS

Rebuilding and hardfacing steel components exposed to metal-metal wear and moderate abrasion.

#### Examples

Wheels and pulleys for the construction and mining industries, rolling bridges, waggons, axles etc.

Repair, rebuilding and under-layers on forge tooling

### TYPICAL ALL-WELD METAL ANALYSIS

<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>Cr</b>
0.2	2.0	0.8	3.0

Structure: martensite + bainite

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit on mild steel: 400 HB

### CONDITIONS OF USE

Current type	Shielding gas	
DC+	EN ISO 14175	M12: Ar + 0.5 – 5 % CO <sub>2</sub>
		M13: Ar + 0.5 – 3% O <sub>2</sub>
		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 – 300	220	16 – 32	28	12 – 25	15
1.6	150 – 300	250	16 – 32	29	12 – 25	20
2.0	200 – 400	300	16 – 32	29	12 – 30	25
2.4	250 – 450	350	16 – 32	29	12 – 30	25

Recovery: 95 %

### WELDING POSITIONS

HARDFACE P-G, up to Ø 1.6 mm, is suitable for positional welding as well as for downhand welding by adapting transfer mode and welding parameters as for solid wires.

### 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.