


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

EN 14700: T Fe1

DESCRIPTION

- Tubular wire for self-shielded metal arc hardfacing
- Hardfacing or rebuilding components subject to metal-metal wear and moderate abrasion
- Machinable deposit

APPLICATIONS

HARDFACE P-O is used for hardfacing and multi-layer build up work. Preheat is required for multi-layer build-up work.

Examples

Tractor rollers, tractor idlers, shovel rollers, crane wheels, mine car wheels, cable drums, cable sheaves, steel mill table rolls and other steel mill applications, shovel track pad, stacker wheels etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Fe
0.20	2.00	0.80	3.00	Bal.

Structure: pearlitic / Martensitic

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-Layer deposit on mild steel: 400 HB

CONDITIONS OF USE

Current type	Shielding
DC+	Self-shielded

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	100 - 300	250	21 - 35	28	12 - 25	20
1.6	150 - 300	270	24 - 35	28	15 - 25	25
2.0	200 - 400	300	26 - 35	28	20 - 50	30
2.4	250 - 450	350	26 - 35	28	25 - 50	40
2.8	250 - 450	400	28 - 35	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.