

**Technical
data sheet**

011121MBA

Cored welding Wire

HARDFACE R-S**CLASSIFICATION**

EN 14700: T Fe8

DESCRIPTION

- Tubular wire for submerged arc hardfacing
- Martensitic weld metal with good cracking and abrasion resistance
- Welding under a flux blanket eliminates the emission of toxic fumes, particularly hexavalent chromium

APPLICATIONS

HARDFACE R-S is used when good resistance to abrasion and impact in dry or wet environments is required.

Examples

Working surfaces of buckets, wear plates and pads, and similar equipment for the construction, mining and dredging industries; mill rolls, conveyor screws and chutes.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr
0.3	2.0	1.0	5.7

Structure: martensite

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit:

As welded: 44 – 48 HRc

FLUX DESCRIPTION

	WA FLUX 325	WA FLUX 385	WA FLUX 415	WA ULTRAFLUX
EN ISO 14174 class	S A AB 1 65	S A AF 2 64	S A FB 1 55	S A FB 1 55

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
2.4	200 - 450	350	26 - 30	30	25 - 40	30
2.8	250 - 550	400	28 - 32	30	25 - 40	30
3.2	300 - 650	500	28 - 32	30	25 - 40	30

Recovery: 95 %

Current type/polarity: DC+

WELDING POSITIONS

Flat

PACKAGING

Diameter	≥ 2.4 mm	
Standard packaging	B 450 coil	Drum
Weight	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.