

<b>Technical data sheet</b>  <small>011121MBA</small>	<b>Cored welding wire</b>  <b>HARDFACE R25-S</b>	
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### CLASSIFICATION

EN 14700: T Fe1

### DESCRIPTION

- Tubular wire for submerged arc hardfacing
- Low carbon, low alloy steel deposit ideally suited for heavy multi-layer build up work
- Welding under a flux blanket eliminates the emission of toxic fumes, particularly hexavalent chromium

### APPLICATIONS

HARDFACE R25-S is used for hardfacing components subject to metal-to-metal wear. It is also used for multi-layer build up prior to depositing a harder alloy on top of it.

#### Examples

Continuous casting rollers, components in direct contact with a mating steel or low alloy steel surface. Ideal for components such as crane wheels, stacker-reclaimer wheels, tractor rollers and idlers, trolley wheels, mine car wheels, electric shovel load rollers, gears, steel shafts, steel mill rolls, roll couplings and any components subject to metal-metal wear

### TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo
0.1	1.8	0.6	1.5	0.5

Structure: bainite

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit: 260- 300 HB

### 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 - 60	30
2.8	250 - 550	400	28 - 32	30	25 - 60	30
3.2	300 - 650	500	28 - 32	30	25 - 60	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.