

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

EN 14700: T Fe1

DESCRIPTION

- Low alloy tubular wire for self-shielded metal arc hardfacing
- Used for the repair of rails
- Low alloy steel weld deposit for heavy multi-layer build-up work on carbon steel parts

APPLICATIONS

Hardface T-O is used for rebuilding and surfacing components subject to metal-metal wear and moderate abrasion. The weld deposit is machinable.

Examples

Build up of earthmoving equipment such as tractor rollers, idlers, chains and drive sprockets, excavator pads, electric shovel track carrier rolls, steel shafts, gears, crane wheels, steel mill rolls, mine car wheels, dredge pins, dredge links, mixer parts, rail car couplings, steel mill roll couplings and any components subject to metal-metal wear.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr
0.15	1.5	0.8	1.5

Structure: bainite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit on mild steel: 360 HB

CONDITIONS OF USE

Current type	Protection
DC+	Self-shielded

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	120 – 320	220	26 – 30	28	25 – 40	30
1.6	150 – 350	270	26 – 30	28	25 – 50	30
2.0	200 – 400	300	26 – 30	28	25 – 50	40
2.4	200 – 450	350	26 – 30	28	25 – 50	40
2.8	250 – 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.