

Technical data sheet

011121MBA

Cored welding wire

HARDFACE T-S**CLASSIFICATION**

EN 14700: T Fe1

DESCRIPTION

- Low alloy tubular wire for submerged arc hardfacing
- The deposit is machinable and resists abrasion and metal-to-metal friction
- May be built up in multiple layers
- Welding under a flux blanket eliminates the emission of toxic fumes, particularly hexavalent chromium

APPLICATIONS

HARDFACE T-S is used for rebuilding and hardfacing of items undergoing abrasive wear. It is also useful as an under-layer on mild and low-alloy steels before hardfacing.

Examples

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 of a 3-layer deposit on mild steel: 360 HB (39 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

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