

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

EN 14700: T ZFe3

DESCRIPTION

- Metal cored wire for gas shielded metal arc hardfacing
- Crack-free rebuilding of forge tooling
- Suited to service temperatures up to 650°C

APPLICATIONS

Together with the complementary products HARDFACE WMOLC-G, the HARDFACE VMOLC-G forms a set of products of increasing hardness specially designed for repair of forging dies.

Large surfaces are hardfaced with HARDFACE VMOLC-G to avoid cracks. Smaller areas and details that are subject to high levels of stress and abrasion are reconstituted using the harder products HARDFACE WMOLC-G. The choice is a compromise between optimum hardness and the need to resist fatigue, abrasion and cracking.

Normal precautions have to be observed during welding: removal of damaged zones, preheating, correct operating temperatures, peening of each layer, and post-weld heat treatment.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	Fe
0.08	1.00	0.60	10.0	1.80	2.50	Bal.

Structure: bainite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit:

As welded 34 - 36 HRC

CONDITIONS OF USE

Current type	Shielding gas
DC+	M12: Ar + 0.5 to 5% CO ₂
	M13: Ar + 0.5 to 3% O ₂
	M21: Ar + 15 to 25% CO ₂

Gas flow rate: 15 to 20 l/min

OPERATING PARAMETERS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.6	200 - 300	250	24 - 33	28	15 - 25	20

Deposit efficiency: 95 %

WELDING POSITIONS

Downhand and inclined, ascending or descending

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

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