

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

EN 14700: T Fe16

### DESCRIPTION

- Special high carbon-chromium-vanadium alloy used in applications where the abrasion and corrosion resistance of high chromium irons is not sufficient.
- Optimised wear resistance due to the vanadium carbides evenly distributed in a hard and tough austenitic matrix

### APPLICATIONS

HARDFACE VN-O is used when extreme abrasion resistance combined with corrosion resistance is required

#### Examples

Concrete and gravel transportation equipment, garbage crushers, various tools undergoing extreme abrasion combined with moderate corrosion

### TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	V	Fe
5.0	0.7	1.2	22.5	10.0	Bal.

Structure: vanadium and chromium carbides in an austenitic hard matrix

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit on mild steel: 62 – 65 HRC

### 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
1.6	150 - 350	250	24 - 30	28	25 - 50	25
2.0	200 - 400	300	26 - 30	28	25 - 50	35
2.4	250 - 450	350	26 - 30	28	25 - 50	40
2.8	250 - 450	400	28 - 32	30	25 - 50	40
3.2	250 - 500	450	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	Spool EN ISO 544: BS 300	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.