

<b>Technical data sheet</b>  <small>011121MBA</small>	<b>Cored welding Wire</b>  <b>HARDFACE W-G</b>	
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### CLASSIFICATION

EN 14700: T ZFe3  
ASME IIC SFA 5.21 / AWS A 5.21: ERcFe-8

### DESCRIPTION

- Tubular wire for gas shielded metal arc hardsurfacing
- Martensitic alloy used in applications where greater hardness of the weld metal is required up to 500°C
- Outstanding resistance to low stress abrasion with heavy impact and high compressive stresses

### APPLICATIONS

HARDFACE W-G is used for hardfacing components subject to metal-to-metal wear and abrasion at elevated temperatures.

#### Examples

Typical applications include refurbishing of steel mill rolls such as blooming mill rolls, leveller rolls, blast furnace bells (burden area), hot work extrusion mandrels, crane wheels and cable sheaves.

### TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	W
0.55	2	0.9	6.5	1.7	1.6

Structure: martensite + carbides

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit on mild steel: 52 - 56 HRC

### CONDITIONS OF USE

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

Gas flow rate: 15 to 20 l/min

### OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	100 – 300	220	18 – 33	28	15 – 30	20
1.6	150 – 350	280	22 – 33	28	15 – 30	25

Recovery: 95 %

### 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.