

Technical data sheet

011121MBA

Cored welding wire

HARDFACE WA212**DESCRIPTION**

- Self-shielded flux cored wire for surfacing or rebuilding bodies of sugar cane shredding rolls
- Spatter is low and the weld pool is easily controlled
- The arc is not affected by draughts or moderate wind

APPLICATIONS

- HARDFACE WA212 is used as buffer layer on mild steels and some cast iron parts before hardfacing with higher abrasion resistance materials.

Examples

Sugar cane shredder roll bodies, gear teeth, conveyor chains, wheels for rolling bridges, shafts, bearing tracks...

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Ni	Al
0.12	1.0	0.4	1.1	2.0

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness - 3-layer deposit - As welded: 85-95 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
1.6	150 - 250	200	16 - 22	20	20 - 25	20
2.0	200 - 300	240	16 - 23	21	20 - 30	25

Recovery: 90 %

WELDING POSITIONS

Flat, half up, half down

PACKAGING

Diameter	1.6 – 2.0 mm	
Standard packaging	EN ISO 544: BS 300 spool	B 450 coil
Weight	15 kg	25 kg

Other packaging and other diameters: please consult us