


Technical data sheet <small>011121MBA</small>	Cored welding wire HARDFACE WA8620-S	 Welding Alloys
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CLASSIFICATION

EN 14700: T Fe1

DESCRIPTION

- Tubular wire for submerged arc cladding of steel mill rolls
- Designed to produce a weld deposit with excellent impact resistance and high strength
- Unique formulation combine with extremely low level of impurities provides a very clean material with attractive properties which make HARDFACE WA8620-S an ideal buffer material for cladding steel mill rolls.

APPLICATIONS

HARDFACE WA8620-S is an ideal buffer material for cladding of components, which are subjected to impact resistance and high strength.

Examples:

Typical applications include cladding of continuous caster rolls and certain rolls used in hot rolling application etc

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	Fe
0.1	1.0	0.3	0.5	0.5	0.2	Rest

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

PWHT	Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
8 hours at 550°C	620	510	25	+20°C : 150

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%

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