

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

EN 14700: T Fe3

#### DESCRIPTION

- Tubular wire for gas shielded metal arc hardfacing
- Martensitic alloy specially formulated for low cracking sensitivity on very large components and alloyed steels
- Good resistance to low stress abrasion

#### APPLICATIONS

HARDFACE WLC-G is used for hardfacing components subject to metal-to-metal wear and abrasion

##### Examples

Typical applications include rebuilding and buffering of steel mill rolls, seats of blast furnace bells and hoppers, moulds for light alloys, forging tooling etc

#### TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	W
0.25	2.0	0.8	6.5	1.5	1.5

Structure: martensite + carbides

#### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit on mild steel: 42 - 46 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 + 12 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.