

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

EN 14700: T Fe3

DESCRIPTION

- Tubular wire for self-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-O 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	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	270	26 – 30	28	25 – 50	30
2.0	250 - 400	300	26 – 30	28	25 – 50	30
2.4	200 – 450	350	26 – 30	28	25 – 50	30
2.8	250 – 550	400	28 – 32	30	25 – 50	30

Recovery: 90 %

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.