

**Technical  
data sheet**

011121MBA

Cored welding wire

**HARDFACE WLC-S****CLASSIFICATION**

EN 14700: T Fe3

**DESCRIPTION**

- Tubular wire for submerged arc hardfacing
- Martensitic deposit giving good resistance to metal-to-metal abrasion under severe compressive stresses combined with impacts
- Crack free multiple layer deposits are achievable
- The deposit is machinable

**APPLICATIONS**

Hardface WLC-S is used for rebuilding thick layers on heavy parts.

**Examples**

Rebuilding of blast furnace hoppers (burden area), mill rolls, forge tooling and moulds. It is also suitable as an under-layer before surfacing with harder materials, particularly HARDFACE W-S.

**TYPICAL ALL-WELD METAL ANALYSIS**

C	Mn	Si	Cr	Mo	W
0.25	2	0.9	6.5	1.5	1.5

Structure: martensite

**TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES**

Hardness – 3-layer deposit on mild steel: 42 - 46 HRc

**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%

Current type/polarity: DC+

**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

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.