

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

EN 14700: T Fe3

### DESCRIPTION

- Metal cored tubular wire for gas shielded metal arc hardfacing
- Martensitic forgeable and heat treatable deposit
- Outstanding resistance to fatigue by impact and high compressive stresses
- High toughness and hardness up to 600°C
- Excellent resistance to corrosion, creep, hot oxidation and plastic deformation

### APPLICATIONS

- Designed for hardfacing high speed and hot work tool steels
- Also suitable for hardfacing mild or low alloy steels

### Examples

Typical applications include rolls, dies, extrusion dies, press tools, hot forming tools, die punches, furnace components etc.

### TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	W	V	Fe
0.3	0.3	0.4	2.4	4	0.6	Bal.

Structure: martensite

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit on mild steel: 47 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 + 15 to 25% CO <sub>2</sub>
EN ISO 14175	

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	16 – 32	28	15 – 25	15
1.6	150 – 300	250	16 – 32	29	12 – 25	20
2.4	250 – 450	350	26 – 32	30	12 – 35	25

Recovery: 95 %

### WELDING POSITIONS

HARDFACE WM-G is suitable as well for downhand as for positional welding by adapting transfer mode and welding parameters as for solid wires.

### 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.