


Technical data sheet <small>011121MBA</small>	Cored welding Wire ROBODUR BN	 Welding Alloys
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CLASSIFICATION

EN 14700: T ZFe13

DESCRIPTION

- Seamless copper coated tubular wire for gas shielded metal arc hardfacing
- Can also be used without gas shielding under certain conditions
- The deposit contains boron carbides which give very good abrasion resistance combined with moderate impact resistance
- Recommended for single layer applications
- Unique welder appeal
- The wire does not pick up moisture, and its arc stability property is excellent

APPLICATIONS

ROBODUR BN is used for hardfacing components undergoing wear by earth, sand and abrasives in agriculture, quarrying, mining and public works applications.

Examples

Mixer shafts, impellers, buckets, shovels, transport screws and crushers for the cement industry.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Ni	B	Fe
0.5	1.0	0.2	1.4	4.8	Bal.

Structure: boron carbides in a martensitic matrix

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness (single-layer deposit on mild steel): 60 - 65 HRc

CONDITIONS OF USE

Current type	Protection
DC+	M12: Ar + 0.5 – 5 % CO ₂
	M13: Ar + 0.5 – 3 % O ₂
	M20: Ar + 5 – 15 % CO ₂
	M21: Ar + 15 – 25 % CO ₂
	Self-shielded <i>A slight weave technique should be applied in order to ensure a defect free deposit</i>

Recovery: 98%

WELDING POSITIONS

ROBODUR BN is primarily used in the flat and horizontal-vertical positions. However, welds in other positions are also possible using the short-circuiting or pulsed arc modes of transfer.

PACKAGING

Diameter	1.2 mm	1.6 mm
	EN ISO 544 – ASME II C SFA-5.2 M	
Spool type	BS300	
Weight	15 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.