Technical data sheet 011121MBA	Coated SMAW Electrode # WA HARDFACE 250-E	Welding Alloys

CLASSIFICATION

EN 14700: E Fe1

DESCRIPTION

- Rutile coated electrode for hardfacing
- Low-alloy bainitic deposit, resistant to impacts and to moderate abrasion and pressure
- Suited to heavy build-up work in multiple layers
- The weld deposit is machinable and free from defects and cracks
- Weldability is excellent even using generators with low striking voltages
- Complements Welding Alloys cored wires HARDFACE B and ROBODUR K 250-G

APPLICATIONS

Rebuilding of worn hardened steel parts or as a buffer layer on ferritic steels before hardfacing with wires providing higher abrasion resistance.

Examples

Transmission shafts, gear teeth, conveyor chains, wheels of cranes and rolling bridges, rollers, bearing tracks and rails. Repairs to and rebuilding of forge tooling.

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Si	Mn	Cr	Fe
0.25	0.5	1.0	1.0	Bal.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness as welded: 250 HB undiluted

OPERATING CONDITIONS

Electrode Ø x L [mm]		2.5 x 350	3.2 x 350	4.0 x 450	5.0 x 450
Current [A]		90	115	160	230
= -	**~ 45V**				

Preheating is not required on mild and medium carbon steels. Low alloyed, high carbon tool steels etc. need to be preheated to 200 - 400°C, depending on their composition and thickness. Cool slowly in still air after surfacing.

WELDING POSITIONS

EN ISO 6947: PA, PC, PF, PE
ASME IX: 1G, 2G, 3G, 4G

PACKAGING

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 450	5.0 x 450
Weight/box [kg]	5	5	6.5	6.5

Other packaging and other sizes: please consult us