


Technical data sheet <small>011121MBA</small>	Tubular SMAW Electrode WA HARDFACE CN-TE	 Welding Alloys
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CLASSIFICATION

EN 14700: T Fe15

DESCRIPTION

- High chromium cast iron with high proportion of complex carbides for applications involving extremely severe abrasive wear and moderate impact.
- The alloy maintains its abrasive resistance up to 450°C.
- The deposit contains chromium and niobium complex carbides in a tough austenitic matrix.

APPLICATIONS

- Typical applications include boiler fan blades, parts in coke plant, sinter and palletising plant hot crusher parts, hot sinter screens, burden areas of blast furnace.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	Nb	Fe
6.5	1.0	0.8	26.0	1.0	8.0	Bal.

Structure: chromium and niobium complex carbides in an austenitic matrix.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit on mild steel: 64 HRC

CONDITIONS OF USE

Electrode Ø x L [mm]	6.0 x 450	8.0 x 450	12.0 x 450
Current [A]	85 - 135	130 - 190	200 - 430

Polarity: AC or DC

WELDING POSITIONS

Flat, half up and half down

PACKAGING

Electrode Ø x L [mm]	Quantity	Weight [kg]
6.0 x 450	~ 61	4 x 5.0
8.0 x 450	~ 36	4 x 5.0
12.0 x 450	~ 17	4 x 5.0

Other packaging and other sizes: please consult us

TIP COLOUR IDENTIFICATION

- Red