

Technical data sheet

011121MBA

Tubular SMAW Electrode

WA HARDFACE HC40-TE**CLASSIFICATION**

EN 14700: T Fe14 - C6Cr40-62

DESCRIPTION

- High chromium cast iron for hardfacing components subjected to extremely severe abrasive wear and moderate impact.
- The deposit contains hard primary chromium carbides in a tough austenitic matrix.

APPLICATIONS

- Typical applications include palm oil extruders, screw conveyors, gyratory crusher cones and mantles, dredge pump bodies, mining and earth moving equipment, agricultural equipment, wear plates, sugar mill crusher hammers, drag line components, quarry and sand handling equipment, brick manufacturing equipment etc.

TYPICAL ALL-WELD METAL ANALYSIS

| C | Mn | Si | Cr | Fe |
|-----|-----|-----|----|-----|
| 6.5 | 0.8 | 0.8 | 40 | Bal |

Structure: Primary Chromium carbides in Austenitic matrix.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit: ~ 62 HRc

CONDITIONS OF USE

| Electrode Ø x L [mm] | 6.0 x 450 | 8.00 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

| Diameter x length [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

- Black