


<b>Technical data sheet</b>  011121MBA	<b>Tubular SMAW Electrode</b>  <b>WA HARDFACE STEELCARBW25-TE</b>	 <b>Welding Alloys</b>
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#### CLASSIFICATION

EN 14700: T ZFe20 - C6Cr23W25-68

#### DESCRIPTION

- Tubular electrode filled with tungsten carbide particles.
- Extreme resistance to abrasives, especially fine-grained.
- Useful in applications which demand very high abrasive resistance materials and moderate impact

#### APPLICATIONS

- Typical application includes material handling components which handles medium to fine particles, coal crusher blades, conveyor screens, concrete mixer components, wood chipping or crushing machine components, brick and clay mill augers etc.

#### TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	WC	Fe
6	0.8	0.8	23	25	Bal

Structure: Tungsten carbides and Fe-Cr-W carbides in austenitic matrix.

#### TYPICAL MECHANICAL PROPERTIES

Hardness:

Multi-Layer: ~ 68 HRC

Carbides: 950 – 2000 HV

#### CONDITIONS OF USE

Electrode Ø x L [mm]	6.0 x 450	8.0 x 450
Current [A]	90 - 130	130 - 180

Polarity: AC or DC

#### WELDING POSITIONS

Flat, half up, half down

#### PACKAGING

Electrode Ø x L [mm]	Quantity	Weight [kg]
6.0 x 450	~ 55	4 x 5.0
8.0 x 450	~ 32	4 x 5.0

Other packaging and other sizes: please consult us

#### TIP COLOUR IDENTIFICATION

- Gold

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.