


<b>Technical data sheet</b>  <small>EN020524GB</small>	<b>Cored welding Wire</b> <b>HARDFACE 40-G</b>	
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### CLASSIFICATION

EN 14700: T Z Fe3

### DESCRIPTION

- Flux cored wire for gas shielded arc welding
- Medium alloyed bainitic steel offering a crack-resistant deposit, especially suited for the repair and rebuilding of forging dies
- Offers a crack-resistant deposit with excellent resistance to low abrasion and moderate impact

### APPLICATIONS

HARDFACE 40-G is used for rebuilding die and sow blocks, rams, die holders and for hot work applications that require to be machined after welding

### TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	Fe
0.10	0.9	0.6	2.0	3.0	1.0	Bal.

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

#### Hardness:

As welded, 3-layer on mild steel: 37 - 42 HRC  
PWHT at 400°C: 38 - 44 HRC

Stress relief at 560 – 580 °C does not affect hardness

The actual hardness for a given application depends on thermal history and dilution from parent material

#### Tensile:

Ultimate Tensile Strength: 1200 MPa

### CONDITIONS OF USE

Current type	Gas-shielding
DC (+)	M21: Ar + 15 - 25 % CO <sub>2</sub>
	M20: Ar + 5 - 15% CO <sub>2</sub>
	M12: Ar + 2 - 5 % CO <sub>2</sub>
	C1: CO <sub>2</sub>

### OPERATING CONDITIONS

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	100 - 300	220	20 - 30	26	15 - 25	20
1.6	150 - 350	270	25 - 35	27	20 - 30	25
2.0	200 - 400	300	25 - 35	28	20 - 30	25
2.4	250 - 450	350	25 - 35	28	20 - 30	25

Recovery: 90 %

### WELDING POSITIONS

Flat

### PACKAGING

Diameter	1.2 - 2.4 mm	2.4 mm	
Standard packaging (EN ISO 544)	BS 300 spool	B 450 coil	Drum
Weight	15 kg	25 kg	Up to 330 kg

Other packaging: 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.