


Technical data sheet <small>EN020524GB</small>	Cored welding Wire HARDFACE 45-G	 Welding Alloys
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CLASSIFICATION

EN 14700: T Fe2

DESCRIPTION

- Metal cored wire for gas shielded arc welding
- Bainitic alloyed steel offering a crack-resistant deposit with a similar chemical analysis and matching colour to AISI P20 tool steel
- Fully compatible when polishing or etching is required
- Can easily be used on lower-grade base metal to provide better wear performance

APPLICATIONS

HARDFACE 45-G is used for rebuilding casting dies, plastic injection moulds die and parts subjected to impact and high compressive stresses

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	Fe
0.40	1.5	0.7	2.5	0.5	Bal.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness:

As welded, 3-layer on mild steel: 43 - 47 HRC

Tensile:

Ultimate Tensile Strength: 1400 MPa

CONDITIONS OF USE

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

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: 98 %

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.