

**Technical data sheet**

EN020524GB

Cored welding Wire

**HARDFACE 45W-G****CLASSIFICATION**

EN 14700: T Fe3

**DESCRIPTION**

- Flux cored wire for gas shielded arc welding
- Martensitic alloyed steel specially formulated for low cracking sensitivity, making it suitable for rebuilding and/or buffering on very large components
- Offers a crack-resistant deposit with excellent resistance to low abrasion and moderate impact
- Low-carbon equivalent of HARDFACE 50W-G

**APPLICATIONS**

HARDFACE 45W-G is used for rebuilding shallow impressions, hot and cold trim dies, shearing dies, extrusion dies, plastic injection moulds, punches, ect.

**TYPICAL ALL-WELD METAL ANALYSIS**

C	Mn	Si	Cr	Mo	W	Fe
0.25	2.0	0.8	6.5	1.5	1.6	Bal.

**TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES****Hardness:**

As welded, 3-layer on mild steel: 42 - 46 HRC

**Tensile:**

Ultimate Tensile Strength: 1350 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.