

Technical data sheet EN180123BG	<p style="text-align: center;">Cored welding wire</p> <h1 style="text-align: center;">HARDFACE Nb-G</h1>	 Welding Alloys
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CLASSIFICATION

EN 14700: T Fe6

DESCRIPTION

- Metal-cored wire for gas shielded metal arc hardfacing
- Produces a hard overlay resisting abrasion and impact
- Finely dispersed hard carbide phases optimise anti-wear properties
- User friendly for welding multiple pass welds as there is no hinder from slag

APPLICATIONS

- HARDFACE Nb-G is designed for hardfacing of items subjected to impact, gouging and abrasion under high stresses. It gives a highly abrasion-resistant crack-free weld metal which may be machined despite its high hardness and is suitable for multi-layer deposits.

Examples

Crushing hammers and rollers, leading edges and teeth of excavator buckets, bulldozer and scraper blades, rotary crusher cones, dipper teeth, etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Nb	Fe
1.5	0.8	0.8	6.5	6.0	Bal.

Structure: martensite with finely dispersed niobium carbide particles.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness - 3 layers on mild steel: 56 HRc

SHIELDING GAS

EN ISO 14175 M12 (Ar + 2 - 5% CO₂)

OPERATING CONDITIONS

Diameter [mm]	Current type*	Current [A]	Voltage [V]	Stick-out	Gas flow
1.2	DC (+), DC (-)	100 - 300	25 - 30	15 - 20 mm	10 - 20 l/min.
1.6	DC (+), DC (-)	200 - 350	25 - 30	15 - 20 mm	10 - 20 l/min.

Recovery: 98%

WELDING POSITIONS

Flat, half up, half down

PACKAGING

Diameter	1.2 - 1.6 mm
Spool type	EN ISO 544 – ASME IIC SFA-5.2M: Basket spool BS300
Weight	15 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.