

HARDFACE 19 9 6-S

For Welding Professionals



Best work hardening austenitic stainless steel



HARDFACE 19 9 6-S is a metal cored wire for submerged arc welding jobs, providing a work hardening austenitic 19Cr-9Ni-6Mn deposit.

It is the ideal solution to maximise the deposition rate (by 35% minimum) when compared to an equivalent solid wire.

When using HARDFACE 19 9 6-S, the travel speed can be increased and the heat input reduced (by up to 30%), therefore having a positive impact on the properties of the polymer filler block.

This wire (in combination with our WAF 325 flux) can be used for both preventative and repair weld overlays.

Why choose this solution?

- The easiest solution to improve performance of submerged arc welding
- Perfectly suited for repairing hard-to-weld steels such as grooved rails
- Overalloyed manganese content helps to improve high pressure and metal-to-metal wear resistance, compared to the equivalent 307 solid wire
- Lower risk of lack of fusion and spalling
- Attractive weld appearance with a clean surface and sound deposit



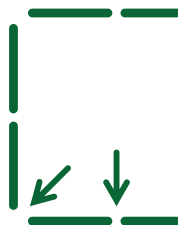
Product Details

Classification: EN ISO 14174 : S A AB 1 65 (flux WAF 325)
EN 14700: T Fe10

Available Diameter: 2.4 mm, 2.8 mm, 3.2 mm

Hardness: 200 HB (as welded, three-layer deposit)
47 HRC (work hardened, three-layer deposit)

Welding Positions:



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