| Technical data sheet<br>011121MBA | Cored welding wire<br># HARDFACE 250-S | Welding Alloys |
|---|---|---|

## CLASSIFICATION

EN 14700: T Fe1

## DESCRIPTION

- Tubular wire for submerged arc hardfacing
- Low alloy bainitic deposit
- Welding under a flux blanket eliminates the emission of toxic fumes, particularly hexavalent chromium

## APPLICATIONS

HARDFACE 250-S is used for rebuilding of worn hardened steel parts or as a buffer layer on ferritic steels before hardfacing with wires providing higher abrasion resistance.

***Examples***

Transmission shafts, gear teeth, conveyor chains, wheels of rolling bridges, bearing tracks etc.

## TYPICAL ALL-WELD METAL ANALYSIS

| C | Mn | Si | Cr | Mo |
|---|---|---|---|---|
| 0.1 | 1.5 | 0.7 | 1.5 | 0.2 |

Structure: bainite

## TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness (3-layer deposit as welded): 250 HB

## FLUX DESCRIPTION

| | WA FLUX 325 | WA FLUX 385 | WA FLUX 415 | WA ULTRAFLUX |
|---|---|---|---|---|
| EN ISO 14174 class | S A AB 1 65 | S A AF 2 64 | S A FB 1 55 | S A FB 1 55 |

## OPERATING CONDITIONS

| Diameter [mm] | Current [A] | | Voltage [V] | | Stick-out [mm] | |
|---|---|---|---|---|---|---|
| | Range | Optimum | Range | Optimum | Range | Optimum |
| 2.4 | 200 - 450 | 350 | 26 - 30 | 30 | 25 - 40 | 30 |
| 2.8 | 250 - 550 | 400 | 28 - 32 | 30 | 25 - 40 | 30 |
| 3.2 | 300 - 650 | 500 | 28 - 32 | 30 | 25 - 40 | 30 |

Recovery : 95 %

Current type/polarity: DC+

## WELDING POSITIONS

Flat

## PACKAGING

| Diameter | ≥ 2.4 mm | |
|---|---|---|
| Standard packaging | B 450 coil | Drum |
| Weight | 25 kg | Up to 330 kg |

Other packaging and other diameters: please consult us