

Technical data sheet

011121MBA

Cored welding wire
HARDFACE B-S

**CLASSIFICATION**

EN 14700: T Fe1

DESCRIPTION

- Tubular wire for submerged arc hardfacing
- Low alloy steel deposit, suitable as an underlayer
- Ideally suited to heavy build-up work in multiple layers
- The weld deposit is machinable and crack free
- Welding under a flux blanket eliminates the emission of toxic fumes, particularly hexavalent chromium

APPLICATIONS

Building up of all components exposed to metal-metal wear in direct contact with a mating carbon steel or low alloy steel surface.

Examples

Crane wheels, trolley wheels, locomotive wheels, gears, steel shafts, idlers, rollers.
Repair, rebuilding and under-layers on forge tooling

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr
0.1	2.2	0.7	1.1

Structure: bainite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit on mild steel: 260 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
3.2	300 - 650	500	28 - 32	30	25 - 50	35

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

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.