| Technical data sheet<br>060122MBA | Cored welding wire<br># HARDFACE CNV-S | Welding Alloys |
|---|---|---|

## CLASSIFICATION

EN 14700: T Fe16

## DESCRIPTION

- Tubular wire for submerged-arc hardfacing
- High chromium cast iron with alloying additions giving a high concentration of hard complex carbides
- The deposit resists extreme conditions of abrasion and temperature up to 700°C
- Welding under a flux blanket eliminates the emission of toxic fumes, particularly hexavalent chromium

## APPLICATIONS

HARDFACE CNV-S is designed to give a weld deposit of particularly high hardness and wear resistance on account of the dispersion of complex carbides it contains. This gives superior performance compared to standard chromium cast irons. Optimum properties are reached in three layers. Relief checking is normal.

***Examples***

Ore sintering, crushing, riddling, blast furnace hoppers and throats, extractor fans etc.

## TYPICAL ALL-WELD METAL ANALYSIS

| C | Mn | Si | Cr | Nb | Mo | W | V |
|---|---|---|---|---|---|---|---|
| 5.5 | 1.5 | 1 | 21 | 6 | 6 | 1.5 | 1 |

Structure: hard primary and secondary complex carbides in a tough austenitic-martensitic matrix.

## TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit on mild steel: 65 HRc

## 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 |
| 2.8 | 250 - 550 | 400 | 28 - 32 | 30 | 25 - 60 | 30 |
| 3.2 | 300 - 650 | 500 | 28 - 32 | 30 | 25 - 60 | 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