Technical Datasheet 011121MBA	Cored welding wire # HARDFACE D-S	Welding Alloys

CLASSIFICATION

EN 14700: T Fe8

DESCRIPTION

- Flux cored wire for submerged arc hardfacing
- Deposit a stainless martensitic alloy
- Very good resistance to thermal fatigue, high temperature metal-metal friction and corrosion

APPLICATIONS

Continuous casting rolls

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	Ni	Co	W	V
0.3	1.0	0.6	13	2	0.5	2.0	1.0	2.0

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness - On a 3-layer deposit on mild steel: 46 - 52 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]	Intensity [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	32	25 - 40	30

ductivity : 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