Technical data sheet 011121MBA	Cored welding wire # HARDFACE DUALHARD C-S	Welding Alloys

CLASSIFICATION

EN 14700: T Fe3

DESCRIPTION

- Tubular wire for submerged arc cladding
- Ferritic-martensitic alloy susceptible to secondary hardening by heat treatment
- High hardness
- Resistant to metal to metal wear at high temperatures and to thermal fatigue

APPLICATIONS

Rebuilding of rolls for hot strip mills, specifically pinch and wrapper rolls

TYPICAL ALL-WELD METAL ANALYSIS

C	Si	Si	Cr	Mo	V	W
0.35	0.8	1.4	6.5	1.5	1.5	1

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness (3-layer deposit on mild steel):

As welded: 55 – 60 HRc

After secondary hardening at 500°C / 6 hours: 57 – 62 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
2.4	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+

Preheat prior to welding and slow cooling afterwards are advisable. Stress relief after welding may also be necessary.

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