Technical data sheet 011121MBA	Cored welding Wire # HARDFACE HC333-O	Welding Alloys

CLASSIFICATION

EN 14700: T Fe14

DESCRIPTION

- Tubular wire for self-shielded metal arc hardfacing
- High chromium cast iron deposit enriched in primary chromium carbides distributed into a tough austenitic matrix
- Highly resistant to abrasive wear and moderate resistance to impacts, with corrosion
- Usually limited to two weld layers, but may be multi-layered for specific applications
- Relief checking of the deposit is normal

APPLICATIONS

HARDFACE HC333-O is used for all applications involving high mineral wear and benefits from a corrosion resistant matrix.
A crack free deposit is possible with a preheat and a minimum interpass temperature of 450 °C followed by oven cooling

Examples
Auger flights, pump housings, mixer parts, conveyer screws, mixer paddles, oil screws, etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo
3.5	0.2	1.0	32.5	0.5

Structure: austenite + chromium carbides

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit on mild steel: 60 HRc

CONDITIONS OF USE

Current type	Protection
DC+	Self-shielded

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.6	160 - 320	250	24 - 30	28	20 - 30	25
2.0	200 - 400	260	25 - 32	29	25 - 40	30
2.4	250 - 450	350	26 - 32	30	25 - 40	30
2.8	250 - 450	400	26 - 32	30	25 - 40	30

Recovery: 90%

WELDING POSITIONS

Flat, half up, half down

PACKAGING

Diameter	≤ 2.4 mm	≥ 2.4 mm	
Standard packaging	EN ISO 544: BS 300 spool	B 450 coil	Drum
Weight	15 kg	25 kg	Up to 330 kg

Other packaging and other diameters: please consult us