


<b>Technical data sheet</b>  <small>011121MBA</small>	<b>Cored welding Wire</b> <b>HARDFACE HC333-O</b>	 <b>Welding Alloys</b>
---	--	---

### 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

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.