Technical data sheet 011121MBA	Cored welding wire # HARDFACE R35-S	Welding Alloys

CLASSIFICATION

EN 14700: T Fe1

DESCRIPTION

- Tubular wire for submerged arc hardfacing
- Low carbon, low alloy steel deposit suited to welding in multiple layers
- Machinable deposit

APPLICATIONS

HARDFACE R35-S is used for hardfacing components subject to impact and high compressive stresses. It can also be used for multi-layer build up work prior to depositing a harder alloy on top of it.

Examples

Continuous casting rollers. crane wheels, trolley wheels, mine car wheels, track pads and rollers. steel shafts, steel mill rolls, roll couplings and any components subject to metal-metal wear

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo
0.15	1.4	0.8	2.2	0.2

Structure: bainite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit: 35 - 40 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 - 60	30
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

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.