Technical data sheet 011121MBA	Cored welding wire # HARDFACE VN-O	Welding Alloys

CLASSIFICATION

EN 14700: T Fe16

DESCRIPTION

- Special high carbon-chromium-vanadium alloy used in applications where the abrasion and corrosion resistance of high chromium irons is not sufficient.
- Optimised wear resistance due to the vanadium carbides evenly distributed in a hard and tough austenitic matrix

APPLICATIONS

HARDFACE VN-O is used when extreme abrasion resistance combined with corrosion resistance is required

Examples

Concrete and gravel transportation equipment, garbage crushers, various tools undergoing extreme abrasion combined with moderate corrosion

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	V	Fe
5.0	0.7	1.2	22.5	10.0	Bal.

Structure: vanadium and chromium carbides in an austenitic hard matrix

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit on mild steel: 62 – 65 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	150 - 350	250	24 - 30	28	25 - 50	25
2.0	200 - 400	300	26 - 30	28	25 - 50	35
2.4	250 - 450	350	26 - 30	28	25 - 50	40
2.8	250 - 450	400	28 - 32	30	25 - 50	40
3.2	250 - 500	450	28 - 32	30	25 - 50	40

Recovery: 90 %

WELDING POSITIONS

Flat, half up, half down

PACKAGING

Diameter	≤ 2.4 mm	≥ 2.4 mm	
Standard packaging	Spool EN ISO 544: BS 300	Coil	Drum
Weight	15 kg	25 kg	Up to 330 kg

Other packaging and other diameters: please consult us