

<b>Technical data sheet</b>  <small>011121MBA</small>	<b>Cored welding wire</b>  <b>HARDFACE VNB-O</b>	 <b>Welding Alloys</b>
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#### CLASSIFICATION

EN 14700: T Fe16

#### DESCRIPTION

- Cored wire for self-shielded metal arc hardfacing
- Chromium cast iron deposit containing complex niobium, vanadium and chromium carbides

#### APPLICATIONS

HARDFACE VNB-O is used for hardfacing components that have to resist abrasion by scratching, up to 650°C

#### Examples

Rotating excavator bucket, lignite crushers-fans, homogenisers for coal or coke, equipment for the electro-metallurgical industry etc.

#### TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	V	Nb	B
5	0.3	1.2	16	7	7	1

Structure: complex carbides in an austenitic matrix

#### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit on mild steel: 62 - 66 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	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.