Technical data sheet 011121MBA	Cored welding wire # HARDFACE X-G	Welding Alloys

CLASSIFICATION

EN 14700 T ZFe8

DESCRIPTION

- Cored wire for gas shielded metal arc hardfacing.
- Deposit provides an even distribution of small primary carbides in a martensitic matrix.
- High hardness and excellent wear resistance.
- Can be applied to produce crack free deposits on some base metals or with specific procedures. Procedure depends on base metal type.

APPLICATIONS

- HARDFACE X-G offers better abrasion resistance than 400 martensitic series stainless steels, tool steels, and in some cases conventional chromium carbides. HARDFACE X-G also has excellent impact resistance.
- To be used for applications where tool steel alloys don't provide enough abrasion resistance, and where chrome carbide alloys are too brittle.
- Limited to 2 layers.

Examples

Drag line bucket lips, auger flights, tire shredders, slitter blades, extruder screws, tamper feet, rendering screws, dredge parts, tamper tools…

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	Others
1.0	0.3	1.0	8.0	0.6	~4.0

Structure: finely dispersed primary carbides in a martensitic matrix

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: As welded: 60-65 HRc

CONDITIONS OF USE

Current type	Shielding gas	
DC+	EN ISO 14175	I1: Ar 100%
		M12: Ar + 0.5 –5% CO_2
		M13: Ar + 0.5 –3% O_2
		M20: Ar + 5 – 15% CO_2
		M21: Ar + 15 – 25% CO_2

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	190 - 280	230	18 - 22	20	12 - 20	15
1.6	190 - 340	260	18 - 22	20	12 - 20	15

WELDING POSITIONS

Flat & horizontal

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