Technical data sheet 011121MBA	Cored welding wire # ROBOTOOL 34W-G	Welding Alloys

CLASSIFICATION

EN 14700: T ZFe8

DESCRIPTION

- Seamless high fill copper coated tubular wire for semi-automatic gas shielded hardfacing
- Unique welder appeal
- Deposition rate increased by up to 20% when compared to solid wire
- Strong and tough hot working steel type deposit for service temperatures up to 550°C
- Wire does not pick up moisture, the wire feeding properties are excellent
- Designed for welding in horizontal, horizontal-vertical and vertical-up positions

APPLICATIONS

Hardfacing parts undergoing metal-to-metal wear, compression and moderate impact loads at high temperatures

Examples:
Hot shear blades, hot and cold punching tools, forging dies, extrusion press pistons, forging and trimming tools etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	W	V	Ti
0.09	0.70	0.50	4.70	0.90	2.30	2.30	0.60	0.1

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: As welded, 3-layer deposit on mild steel: 35 HRc
After PWHT 520°C / 10hrs: 38 HRc

CONDITIONS OF USE

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

OPERATING CONDITIONS

Diameter [mm]	Intensity [A]	Voltage [V]	Stick-out	Gas flow rate
1.2	110 - 300	16 - 32	12 -18 mm	10 - 20 l/min.
1.6	130 - 350	16 - 32	12 -18 mm	10 - 20 l/min.

Recovery: 98 %

WELDING POSITIONS

ROBOTOOL 34W-G is suitable as well for downhand as for positional welding by adapting transfer mode and welding parameters as for solid wires.

PACKAGING

Diameter	1.2 mm	1.6 mm
	EN ISO 544 – ASME II C SFA-5.2 M	
Spool type	BS300	
Weight	15 kg	

Other packaging and other diameters: please consult us