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

CLASSIFICATION

EN 14700: T Fe9

DESCRIPTION

- Flux cored wire for self shielded metal arc hardfacing
- Austenitic deposit with excellent work hardening properties
- Highly resistant to impact and high pressures

APPLICATIONS

HARDFACE APRAIL-O produces an austenitic, non-magnetic weld deposit which has excellent work hardening properties. The degree of work hardening is dependent on the amount of impact on the rebuilt component. It is used for rebuilding components exposed to high impact or heavy loads and can be welded on ferritic and austenitic steels including “Hadfield” manganese steel. It is an excellent buffer layer prior to hardfacing with high chromium cast iron. The deposit can be multi-layered without limit.

Examples

Repairing railway frogs and crossings, railway wheels, pulleys, capstans etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni
0.4	16	0.5	14	1.4

Structure: austenite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit

as welded: 210 - 240 HB

work hardened: 45 – 55 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
1.2	100 - 300	250	21 - 35	28	25 - 50	25
1.6	150 - 350	270	24 - 35	28	25 - 50	25
2.0	200 - 400	300	26 - 35	28	25 - 50	35
2.4	250 - 450	350	26 - 35	28	25 - 50	40
2.8	250 - 450	400	28 - 35	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