

## HARDFACE 19 9 6-G

CLASSIFICATION				
EN 14700 T Fe10				
DESCRIPTION				
<ul style="list-style-type: none"><li>• Tubular wire for gas shielded metal arc hardfacing</li><li>• Austenitic stainless weld deposit</li><li>• Good impact, cavitation and corrosion resistance</li><li>• The weld deposit work hardens to different degrees depending on amount of impact</li><li>• Resists scaling up to 850°C, good resistance to thermal shocks</li></ul>				
APPLICATIONS				
<ul style="list-style-type: none"><li>• Hardface 19 9 6-G is mainly used to rebuild components exposed to high impact and corrosion.</li><li>• Sub-layer before hardfacing</li></ul>				
<b>Examples</b>				
Steel mill rolls, metallurgical plant guides, tram and train rails and fittings, high speed forming rolls				
TYPICAL ALL-WELD METAL ANALYSIS				
<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>Cr</b>	<b>Ni</b>
0.10	6.00	0.50	19.0	9.0
Structure: austenite				
TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES				
Hardness – 3-Layer deposit:				
As welded 180 HB			Work hardened: 47 HRc	
CONDITIONS OF USE				
<b>Current type</b>		<b>Shielding gas</b>		
DC (+)	EN ISO 14175	M12 / M13 / M20 / M21		
OPERATING CONDITIONS				

Diameter [mm]	Amperage [A]	Voltage [V]	Stick-out [mm]	Gas flow [l/min]
1.2	100 - 300	24 - 32	12 - 25	10 - 20
1.6	150 - 300	24 - 32	12 - 25	10 - 20
2.0	200 - 400	24 - 32	12 - 30	10 - 20
2.4	250 - 450	24 - 32	12 - 30	10 - 20

Recovery: > 95 %

#### WELDING POSITIONS

Hardface 19 9 6-G, up to  $\varnothing$  1.6 mm, is suitable as well for downhand as for positional welding by adapting transfer mode and welding parameters as for solid

#### STANDARD DIAMETERS (mm)

1.2, 1.6, 2.0, 2.4

Other diameters: please consult us

#### PACKAGING

Diameter	$\leq 2.4$ mm		$\geq 2.4$ mm
Standard packaging [EN ISO 544]	Spool : BS 300	Coil : B 450	Drum
Weight	15 kg	25 kg	Up to 330 kg