

**HARDFACE 19 9 6-S**

**CLASSIFICATION**

EN 14700 T Fe10

**DESCRIPTION**

- Tubular wire for submerged arc hardfacing
- Austenitic stainless weld deposit
- Good impact, cavitation and corrosion resistance
- The weld deposit work hardens to different degrees depending on amount of impact
- Resists scaling up to 850°C, good resistance to thermal shocks

**APPLICATIONS**

- Hardface 19 9 6-G is mainly used to rebuild components exposed to high impact and corrosion.
- Sub-layer before hardfacing

**Examples**

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**

**Current type**

DC (+)

**Shielding**

WAF 325 or WAF 385

<b>FLUX DESCRIPTION</b>	<b>WAF 325</b>	<b>WAF 385</b>
-------------------------	----------------	----------------

FLUX DESCRIPTION	WAF 325	WAF 385
Classification	EN 760: S A FB 1 65 DC H5	EN 760: S A AB 2 65 DC H5
Redrying	2 hours at 250 - 350°C	
Packaging	bags (25 kg)	

#### OPERATING CONDITIONS

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.6	150 - 300	250	26 - 32	30	15 - 30	25
2.0	200 - 350	270	26 - 32	30	20 - 50	25
2.4	200 - 450	350	26 - 32	30	25 - 50	30
2.8	250 - 550	400	28 - 32	30	25 - 50	30
3.2	300 - 650	500	28 - 32	30	25 - 50	30

Recovery: 95 %

#### WELDING POSITIONS

Flat

#### STANDARD DIAMETERS (mm)

1.6, 2.0, 2.4, 2.8, 3.2

Other diameters: please consult us

#### PACKAGING

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