HARDFACE 19 9 6-O

CLASSIFICATION

EN 14700 T Fe10

DESCRIPTION

- Tubular wire for self-shielded metal 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-O 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

C	Mn	Si	Cr	Ni
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	Shielding
DC (+)	Self shielded

OPERATING CONDITIONS

Diameter	Amperage [A]		Voltage [V]		Stick-out [mm]	
[mm]	Range	Optimum	Range	Optimum	Range	Optimum
1.2	100 - 300	250	21 - 35	28	12 - 25	15
1.6	150 - 300	270	24 - 35	28	15 - 25	20
2.0	200 - 400	300	26 - 35	28	20 - 50	30
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

STANDARD DIAMETERS (mm)

1.2, 1.6, 2.0, 2.4, 2.8

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