

HARDFACE AP-G

CLASSIFICATION

EN 14700 T Fe9

DESCRIPTION

- Cored wire for gas shielded metal arc hardfacing
- Austenitic deposit with excellent work hardening properties

APPLICATIONS

Hardface AP-G produces an austenitic and 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 used on ferritic and austenitic steels including “Hadfield” manganese steel. Deposit can be multi-layered

Examples

Railroad frogs, crusher rolls, hammers, steel mill rolls and all components where a work hardening deposit is desirable.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Fe
0.40	16.0	0.50	14.0	Bal

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

DC (+)

Shielding gas

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 AP-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 wires.

STANDARD DIAMETERS (mm)

1.2, 1.6, 2.0, 2.4

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