HARDFACE AP-O

CLASSIFICATION

EN 14700 T Fe9

DESCRIPTION

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

APPLICATIONS

Hardface AP-O 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	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