

## HARDFACE AP-S

### CLASSIFICATION

EN 14700 T Fe9

### DESCRIPTION

- Tubular wire for submerged arc hardfacing
- Austenitic deposit with excellent work hardening properties

### APPLICATIONS

Hardface AP-S 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	16.00	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

WAF 325 or WAF 385

### 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

Other packaging: please consult us