HARDFACE B-O

CLASSIFICATION

EN 14700 T Fe1

DESCRIPTION

• Tubular wire for self-shielded metal arc hardfacing

• Low alloys and crack-resistant steel deposit

APPLICATIONS

Hardface B-O is ideally suited for heavy multi-layer build up work. Weld deposit is machinable.

Examples

Build up of all components exposed to metal-metal wear. Components in direct contact with a mating carbon steel or low alloy steel surface.Ideal for components such as crane wheels, trolley wheels, locomotive wheels, gears, steel shafts, idlers, rollers and any components subject to metal-metal wear.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Fe
0.10	1.50	0.40	1.00	Rest

Structure: bainite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-Layer deposit on mild steel: 260 HB

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	20
1.6	150 - 300	280	24 - 35	28	15 - 25	25

Diameter	Amperage [A]		Voltage [V]		Stick-out [mm]	
[mm]	Range	Optimum	Range	Optimum	Range	Optimum
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