

HARDFACE B-S

CLASSIFICATION

EN 14700 T Fe1

DESCRIPTION

- Tubular wire for submerged arc hardfacing
- Low alloy and crack-resistant steel deposit

APPLICATIONS

Hardface B-S 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

DC (+)

Shielding

WAF 325

FLUX DESCRIPTION

WAF 325

Classification	EN 760: S A FB 1 65 DC H5
Redrying	2 hours at 250 - 350°C
Packaging	bags (25 kg)

OPERATING CONDITIONS

Diameter	Amperage [A]	Voltage [V]	Stick-out [mm]
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[mm]	Range	Optimum	Range	Optimum	Range	Optimum
1.6	150 - 300	250	26 - 32	30	15 - 30	25
2.0	200 - 350	280	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