

HARDFACE BN-O

CLASSIFICATION

EN 14700 T ZFe13

DESCRIPTION

- Tubular wire for self-shielded metal arc hardfacing
- Alloy designed for hardfacing of unalloyed steels to achieve extreme abrasion resistance
- The abrasion resistance and hardness are achieved in one layer thus allowing interesting cost saving

APPLICATIONS

Hardface BN-O is used for hardfacing on to unalloyed steels with C < 0.5% to achieve required abrasive wear resistance in single layer.

Examples

Equipment used in agriculture, quarrying, mining and civil engineering e.g. screw conveyors, hoppers, strimmer cutters, etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Ni	B	Fe
0.50	2.00	1.30	2.00	4.50	Rest

Structure: hard borides in a eutectic matrix

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-Layer deposit as welded: 65 HRc

CONDITIONS OF USE

Current type	Shielding gas
DC (+)	Self shielded

OPERATING CONDITIONS

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	100 - 300	250	21 - 35	28	12 - 25	20
1.6	150 - 300	270	24 - 35	28	15 - 25	25

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