

# HARDFACE BNC-O

## CLASSIFICATION

EN 14700 T ZFe3

## DESCRIPTION

- Tubular wire for self-shielded metal arc hardfacing
- Alloy designed for extreme resistance to high stress grinding abrasion with moderate impact
- The abrasion resistance and hardness are achieved in one layer thus allowing interesting cost saving
- Suitable for service temperatures up to 650°C

## APPLICATIONS

The deposit resists abrasion by small particles under high restraint or erosion in gaseous media.

### Examples

Periphery and leading flight on ceramic augers, blast furnace bells and screens operating at high temperature, agglomeration fans, sinter stars, sinter exhausters etc.

## TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Nb	B	Fe
2.50	2.00	0.60	11.5	5.00	2.20	Rest

Structure: borides and niobium carbides in a hard eutectic matrix

## TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-Layer deposit as welded: 64-68 HRc

## CONDITIONS OF USE

Current type	Shielding
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