

HARDFACE CN-O

CLASSIFICATION

EN 14700 T Fe15

DESCRIPTION

- Tubular wire for self shielded metal arc hardfacing
- High chromium cast iron for hardfacing components subject to extremely severe abrasive wear and heavy impact up to 300°C
- The deposit contains hard complex carbides in a tough matrix and performs exceptionally well in both fine and coarse abrasion

APPLICATIONS

Hardface CN-O is used for hardfacing components undergoing heavy wear by earth, sand or other abrasives. Relief checking is normal.

Examples

Sand and earthmoving equipment such as buckets and teeth, railway ballast tampers, dredge buckets and lips, dragline buckets, coke hammers, rippers, sizing screens, crushing equipment, brick industry components, Muller tyres, catalyst lift pipes, pump impellers, fan blades, rockwool rolls, wear plates operating at high temperature in the steelmaking industry.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Nb	Fe
5.00	0.50	0.70	22.00	7.00	Rest

Structure: chromium and niobium carbides in an austenitic matrix. Niobium carbides increase abrasion and impact resistance compared to classical high chromium cast irons

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit on mild steel: 62 – 65 HRc

CONDITIONS OF USE

Current type	Shielding gas
DC (+)	Self shielded

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	270	26 - 35	28	25 - 25	25
2.0	200 - 400	300	26 - 35	28	25 - 50	35
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)

1.6, 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