# HARDFACE CNV-O

## CLASSIFICATION

EN 14700 T Fe16

## DESCRIPTION

• Tubular wire for self shielded metal arc hardfacing

• Highly-alloyed chromium cast iron with a high concentration of complex carbides

• High chromium cast iron for hardfacing components subject to extremely severe abrasive wear and moderate impact up to 600°C.

## APPLICATIONS

Hardface CNV-O is designed to give a weld deposit of particularly high hardness and wear resistance on account of the dispersion of complex carbides it contains. This gives superior performance compared to standard chromium cast irons. The properties are reached in only three layers and relief checking is normal.

***Examples***

Used for crushing, riddling, blast furnace hoppers and throats, ovens, extractor fans etc.

## TYPICAL ALL-WELD METAL ANALYSIS

| C | Mn | Si | Cr | Nb | Mo | W | V | Fe |
|---|---|---|---|---|---|---|---|---|
| 5.50 | 0.50 | 1.50 | 22.00 | 6.00 | 5.50 | 2.00 | 1.00 | Rest |

Structure: hard primary chromium and complex carbides in a tough secondary carbide eutectic matrix

## TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit on mild steel: 64 – 66 HRc

## CONDITIONS OF USE

| Current type | Shielding gas |
|---|---|
| DC (+) | Self shielded |

## OPERATING CONDITIONS

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

| Diameter | Amperage [A] | | Voltage [V] | | Stick-out [mm] | |
|---|---|---|---|---|---|---|
| [mm] | Range | Optimum | Range | Optimum | Range | Optimum |
| 1.6 | 150 - 350 | 270 | 26 - 35 | 28 | 25 - 50 | 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 | 26 - 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 |