HARDFACE CV-O

CLASSIFICATION

EN 14700 T Fe16

DESCRIPTION

• Tubular wire for self shielded metal arc hardfacing

• Low cost version of the CNV-O giving almost comparable results

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

APPLICATIONS

Hardface CV-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. Relief checking is normal.

Examples

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

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Nb	Mo	W	V	Fe
5.50	0.50	1.00	22.0	6.20	3.30	1.00	0.45	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: 63-65 HRc

CONDITIONS OF USE

Current type	Shielding
DC (+)	Self shielded

OPERATING CONDITIONS

Diameter	Amperage [A]		Voltage [V]		Stick-out [mm]	
[mm]	Range	Optimum	Range	Optimum	Range	Optimum
1.6	150 - 300	270	24 - 35	28	15 - 25	25
2.0	200 - 400	300	26 - 35	28	20 - 50	30
2.4	250 - 450	350	26 - 35	28	25 - 50	40

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