

HARDFACE HC-O

CLASSIFICATION

EN 14700 T Fe15

DESCRIPTION

- High chromium cast iron for hardsurfacing components subject to extremely severe abrasive wear and moderate impact
- The deposit contains a high proportion of hard primary chromium carbides in a tough austenitic matrix

APPLICATIONS

Hardface HC-O is used for hardfacing components undergoing wear by earth, sand and abrasives.

Examples

Gyratory crusher cones and mantles, catalyst pipes and valves, slurry pipes and valve bodies, dredge pump bodies, sand dredge parts, extruder screws, “barmac” crushers, mining and earthmoving equipment, blast furnace bells, brick muller tyres, sugar mill crusher hammers, drag line components, coal pulverisor rolls, coke hammers, cone knives and shredders. Relief checking is normal and best limited to two layers unless impact loading is small. Can be multi-layered in specific applications.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Fe
5.00	1.50	1.50	27.0	Rest

Structure: primary carbides and eutectic carbides of the M7C3 type in an austenitic matrix

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-Layer deposit on mild steel: 60-62 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

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