

# HARDFACE L-O

## CLASSIFICATION

EN 14700 T Fe8

## DESCRIPTION

- Tubular wire for self-shielded metal arc hardfacing
- Martensitic weld metal with good abrasion and impact resistance
- Self-tempering deposit for hardfacing
- Especially applicable in 2-3 layers for wear resistance

## APPLICATIONS

Hardface L-O is used when good resistance to abrasion and impact in dry or wet environments is required.

### Examples

Bucket teeth, lips and undersides, cutting edges, steel mill rolls, cable drums, sand dredge equipment, dragline buckets, conveyor chutes, grizzly bars..

## TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Fe
0.50	1.50	2.50	8.50	Rest

Structure: austenite

## TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-Layer deposit:

As welded 56-59 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

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
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