

HARDFACE L-S

CLASSIFICATION

EN 14700 T Fe8

DESCRIPTION

- Tubular wire for submerged 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-S 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: medium alloy martensitic

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-Layer deposit
as welded: 55 - 58 HRc

CONDITIONS OF USE

Current type

DC (+)

Shielding

WAF 325

FLUX DESCRIPTION

WAF 325

Classification	EN 760: S A FB 1 65 DC H5
Redrying	2 hours at 250 - 350°C
Packaging	bags (25 kg)

OPERATING CONDITIONS

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.6	150 - 300	250	26 - 32	30	15 - 30	25
2.0	200 - 350	280	26 - 32	30	20 - 50	25
2.4	200 - 450	350	26 - 32	30	25 - 50	30
2.8	250 - 550	400	28 - 32	30	25 - 50	30
3.2	300 - 650	500	28 - 32	30	25 - 50	30

Recovery: 95 %

WELDING POSITIONS

Flat

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