

# HARDFACE P-O

## CLASSIFICATION

EN 14700 T Fe1

## DESCRIPTION

- Tubular wire for self-shielded metal arc hardfacing
- Hardfacing or rebuilding components subject to metal-metal wear and moderate abrasion
- Machinable deposit

## APPLICATIONS

Hardface P-O is used for hardfacing and multi-layer build up work. Preheat is required for multi-layer build-up work

### Examples

Tractor rollers, tractor idlers, shovel rollers, crane wheels, mine car wheels, cable drums, cable sheaves, steel mill table rolls and other steel mill applications, shovel track pad, stacker wheels etc.

## TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Fe
0.20	2.00	0.80	3.00	Rest

Structure: pearlitic/martensitic

## TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-Layer deposit on mild steel: 400 HB

## CONDITIONS OF USE

Current type	Shielding
DC (+)	Self shielded

## OPERATING CONDITIONS

Diameter	Amperage [A]	Voltage [V]	Stick-out [mm]
[mm]	Range	Optimum	Range
		Optimum	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	15
1.6	150 - 300	270	24 - 35	28	15 - 25	20
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