

# HARDFACE P-S Mod

## CLASSIFICATION

EN 14700 T Fe1

## DESCRIPTION

- Tubular wire for submerged arc hardfacing
- Hardfacing or rebuilding components subject to metal-metal wear and moderate abrasion
- Modified version of Hardface P-S wire to achieve improved mechanical properties
- Machinable deposit

## APPLICATIONS

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

### Examples

Marine engine parts, 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   | Mo | Fe   |
|------|------|------|------|----|------|
| 0.20 | 2.00 | 0.80 | 3.00 | +  | Rest |

## TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-Layer deposit on mild steel: 40 - 45 HRc

## CONDITIONS OF USE

| Current type | Shielding |
|--------------|-----------|
| DC (+)       | WAF 325   |

## FLUX DESCRIPTION

| 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 | Amperage [A] | Voltage [V] | Stick-out [mm] |
|----------|--------------|-------------|----------------|
|----------|--------------|-------------|----------------|

| [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 |