

HARDFACE P-S

CLASSIFICATION

EN 14700 T Fe1

DESCRIPTION

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

APPLICATIONS

Hardface P-S 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 (+)	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