

HARDFACE STEELCARB W-O

CLASSIFICATION

EN 14700 T Fe20

DESCRIPTION

- Tubular hardfacing wire for self-shielded metal arc hardfacing
- Composite wire is made from a steel strip filled with tungsten carbide pa
- Weld deposit is extremely resistant to abrasions with moderate impact

APPLICATIONS

Hardface STEELCARBW-O is used for hardfacing components subject to extreme abrasion with moderate impact. The uniformly dispersed fine carbide particles in steel matrix greatly enhance the wear resistance of the material.

Examples

Dust extractor ventilators in the mining, cement and steel industries, scrapper blades, components for agriculture, etc

TYPICAL ALL-WELD METAL ANALYSIS

| Fused Tungsten Carbide | Steel Matrix |
|---|--------------|
| 50 to 60 wt. % depending on wire diameter | Balance |

Structure: uniformly distributed fused tungsten carbide in a martensitic matrix

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 1 layer on mild steel: 52 – 62 HRc

2 layers on mild steel: 60 -64 HRc

CONDITIONS OF USE

| Current type | Shielding gas |
|--------------|---------------|
| DC (+) | Self shielded |

OPERATING CONDITIONS

| Diameter [mm] | Amperage [A] Range | Voltage [V] Range | Stick-out [mm] Range |
|---------------|--------------------|-------------------|----------------------|
| 1.6 | 120 - 200 | 22 - 27 | 15 - 40 |
| 2.0 | 130 - 240 | 23 - 28 | 20 - 50 |

| Diameter [mm] | Amperage [A] Range | Voltage [V] Range | Stick-out [mm] Range |
|------------------|-----------------------|----------------------|-------------------------|
| 2.4 | 150 - 280 | 24 - 28 | 25 - 50 |
| 2.8 | 200 - 350 | 24 - 28 | 25 - 50 |

Recovery: 95 %

WELDING POSITIONS

Flat, downhand

STANDARD DIAMETERS (mm)

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 |