HARDFACE T-O

CLASSIFICATION

EN 14700 T Fe1

DESCRIPTION

• Tubular wire for self-shielded metal arc hardfacing

• Low alloy steel weld deposit for heavy multi-layer build-up work on carbon steel parts

APPLICATIONS

Hardface T-O is used for rebuilding and surfacing components subject to metal-metal wear and moderate abrasion. The weld deposit is machinable.

Examples

Build up of earthmoving equipment such as tractor rollers, idlers, chains and drive sprockets, excavator pads, electric shovel track carrier rolls, steel shafts, gears, crane wheels, steel mill rolls, mine car wheels, dredge pins, dredge links, mixer parts, rail car couplings, steel mill roll couplings and any components subject to metal-metal wear.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Fe
0.15	1.50	0.80	1.50	Rest

Structure: bainite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-Layer deposit on mild steel: 360 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	Range	Optimum

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