

# HARDFACE TIC-O/G

## CLASSIFICATION

EN 14700 T Fe8

## DESCRIPTION

- Tubular hardsurfacing wire for open arc welding
- High Chromium cast iron for hardfacing components subject to severe abrasion and heavy impact
- The weld deposit contains finely dispersed Titanium Carbide particles in a high chromium martensitic matrix

## APPLICATIONS

Hardface TiC-O is designed for excellent resistance to heavy impact , gouging and grinding abrasion. Some relief checking is normal but can be minimised by use of suitable preheat.

### Examples

Augers, Scraper blades, mixer tyres, brick dies, earthmoving and crushing equipment.

## TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	Ti
1.80	1.20	0.70	6.50	0.80	5.00

## TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit on mild steel: 57 HRc

## CONDITIONS OF USE

### Current type

DC (+)

### Shielding gas

Self shielded

## OPERATING CONDITIONS

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	140 - 230	200	23 - 32	28	25 - 50	30
1.6	180 - 300	250	23 - 32	28	25 - 50	30
2.0	200 - 400	300	26 - 32	28	25 - 50	35

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
2.4	250 - 450	350	26 - 32	28	25 - 50	40
2.8	250 - 450	400	28 - 32	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