

HARDFACE TN-O

CLASSIFICATION

EN 14700 T Fe3

DESCRIPTION

- Tubular hardfacing wire for open arc welding
- Especially designed and developed wire composition to achieve fully bainitic microstructure in the weld deposit which provides excellent wear resistance, strength and toughness

APPLICATIONS

Hardface TN-O is especially designed for repair welding of track steels (rail steels, crane tracks etc.)

TYPICAL ALL-WELD METAL STRUCTURE

Bainite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-Layer deposit on mild steel: 300 - 380 HV

CONDITIONS OF USE

Current type

DC (+)

Shielding

Self shielded

OPERATING CONDITIONS

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

Recovery: 90%

WELDING POSITIONS

Flat, half up, half down

STANDARD DIAMETERS (mm)

1.2, 1.6

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