

HARDFACE VN-O

CLASSIFICATION

EN 14700 T Fe16

DESCRIPTION

- Tubular wire for self-shielded metal arc hardfacing
- Chromium carbide type matrix with vanadium carbide particles dispersed uniformly throughout the deposit thickness
- For improving abrasion resistance: ideal complement to conventional chromium carbide deposits at the deposits at the final pass or for local reinforcement.

APPLICATIONS

Hardface VN-O is used for hardfacing components undergoing heavy wear by earth, sand or other abrasives. Relief checking is normal.

Examples

Used for mixer blades, extruder screws, crusher component armoring, tile and brick making equipment etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	V	Fe
5.00	0.50	1.20	22.5	10.0	Rest

Structure: chromium and vanadium carbides in an austenitic matrix

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-Layer deposit on mild steel : 62-64 HRc

CONDITIONS OF USE

Current type

Shielding gas

DC (+) Self shielded

OPERATING CONDITIONS

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.6	150 - 350	270	26 - 35	28	25 - 50	25
2.0	200 - 400	300	26 - 35	28	25 - 50	35
2.4	250 - 450	350	26 - 35	28	25 - 50	40

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
2.8	250 - 450	400	26 - 35	30	25 - 50	40

Recovery: 90 %

WELDING POSITIONS

Flat, half up, half down

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