Technical data sheet EN020724GB	Cored welding wire # HARDFACE TIC-O	Welding Alloys

CLASSIFICATION

EN 14700: T Fe8

DESCRIPTION

- Cored wire for self shielded metal arc hardfacing
- Finely dispersed titanium and chromium carbides in an austenitic matrix
- Dedicated to hardfacing of components subject to extreme abrasion, high pressure and heavy impact

APPLICATIONS

HARDFACE TIC-O is ideal for excellent resistance to heavy impact, gouging and grinding abrasion. Some relief checking is normal but can be minimised by suitable preheat. It may be applied in multiple layers on massive pieces.

Examples

Augers, scraper blades, mixer tyres, brick dies, hammers, earthmoving equipment, crushing equipment, mining equipment, shovel buckets, slurry pipes, cane knives and shredders

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	Ni	Ti	V
2	1.2	1.2	7.3	1.2	1	5.5	0.2

Structure: austenitic matrix with dispersed titanium carbide particles

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit on mild steel: 57 – 60 HRc

CONDITIONS OF USE

Current type	Protection
DC- preferably, DC+	Self-shielded

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	100 - 300	250	21 - 35	28	25 - 50	25
1.6	150 - 350	270	24 - 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
2.8	250 - 450	400	28 - 35	30	25 - 50	40

Recovery: 85 %

WELDING POSITIONS

Flat, half up, half down

PACKAGING

Diameter	≤ 2.4 mm	≥ 2.4 mm	
Standard packaging	EN ISO 544: BS 300 spool	B 450 coil	Drum
Weight	15 kg	25 kg	Up to 330 kg

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.