

<b>Technical data sheet</b>  <small>100122MBA</small>	<b>Cored welding wire</b>  <b>HARDFACE STAINCARBW</b>	 <b>Welding Alloys</b>
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### CLASSIFICATION

EN 14700: T Fe20

### DESCRIPTION

- Tubular wire for self-shielded or gas shielded metal arc hardfacing
- Wire is made from a stainless steel strip filled with cast tungsten carbides
- Weld deposit is extremely abrasion resistant

### APPLICATIONS

HARDFACE STAINCARBW is used for hardfacing components subject to extreme abrasion and moderate impact. The tungsten carbide particles are uniformly dispersed in a high chrome alloy matrix. The matrix is suitable for applications in corrosive media, as in the food preparation industry.

#### Examples

Mixers, beaters, helices, screw-flights

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 1 layer on mild steel: 52 – 62 HRc  
 2 layers on mild steel: 60 – 63 HRc

### CONDITIONS OF USE

Current type	Protection
DC+	M21: Ar + 15 - 25%CO <sub>2</sub> M12: Ar + 0,5 - 5% CO <sub>2</sub> Self-shielded

Surfaces to be welded should be free of rust, scale, oil or any other contamination

Work with low heat input to avoid melting or sinking of the tungsten particles should be favoured

### OPERATING CONDITIONS

Diameter [mm]	Current [A]	Voltage [V]	Stick-out [mm]
1.6	120 – 180	22 – 27	12 – 60
2.0	130 – 190	23 – 28	15 – 60
2.4	220 – 280	24 – 27	15 – 60
2.8	280 – 350	22 – 28	25 – 60

Recovery: 95 %

### WELDING POSITIONS

Flat, half up, half down,

All positions (1.6 mm)

HARDFACE STAINCARBW, up to Ø 1.6 mm, is suitable as well for flat & horizontal as for positional welding by adapting transfer mode and welding parameters.

### 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.