

Cored welding wire

011121MBA

HARDFACE MAXIMPACT



CLASSIFICATION

EN 14700:

T Fe9

DESCRIPTION

- Flux-cored wire for self shielded metal arc hardfacing
- Austenitic deposit with excellent work hardening properties
- Extremely resistant to impact and high pressures

APPLICATIONS

HARDFACE MAXIMPACT produces an austenitic, non-magnetic weld deposit which has excellent work hardening properties. The degree of work hardening depends strongly on the amount of impact. It is used for rebuilding components exposed to abrasion, high impact and heavy loads and can be welded on to ferritic and austenitic steels including "Hadfield" manganese steel. It improves component lifetime by at least 25% compared with conventional manganese-alloyed products. The deposit can be multi-layered.

Examples

Building up of crusher rotors and crusher bars.

TYPICAL ALL-WELD METAL ANALYSIS

ITFICAL ALL-WEED METAL ANALISIS					
C	Mn	Si	Cr	Ni	
0.8	20	0.4	2.5	1	

Structure: austenite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer de	eposit
as welded:	250 HB
work-hardened:	45 – 55 HRC

CONDITIONS OF USE

Current type	Protection
DC+	Self-shielded

OPERATING CONDITIONS

Diameter	Curr	Current [A]		Voltage [V]		Stick-out [mm]	
[mm]	Range	Optimum	Range	Optimum	Range	Optimum	
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: 90 %

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.