Technical data sheet 011121MBA	Cored welding wire # HARDFACE MAXIMPACT	Welding Alloys

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

C	Mn	Si	Cr	Ni
0.8	20	0.4	2.5	1

Structure: austenite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit

as welded: 250 HB

work-hardened: 45 – 55 HRC

CONDITIONS OF USE

Current type	Protection
DC+	Self-shielded

OPERATING CONDITIONS

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