


Technical data sheet <small>011121MBA</small>	Coated SMAW Electrode WA HARDFACE CN-E	 Welding Alloys
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CLASSIFICATION

EN 14700 : E Fe15

DESCRIPTION

- High recovery basic electrode with pleasing arc characteristics and a slag-free deposit.
- High chromium cast iron with niobium and chromium carbides
- Very good wear resistance to fine abrasive particles of high hardness
- Maintains its abrasion resistance up to 450°C
- Very high recovery rate: 190%

APPLICATIONS

WA HARDFACE CN-E is designed for surfacing parts subjected to heavy abrasion with moderate impact.

Examples

Riddling, blast furnace hoppers, extractor fans, cement presses, mixer blades, brick presses etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Si	Cr	Nb
5	1.5	24	7

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit on mild steel: ~ 64 HRc

OPERATING CONDITIONS

Electrode Ø x L [mm]	3.2 x 350	4.0 x 450	5.0 x 450
Current [A]	130 - 150	140 - 190	190 - 250
= +	~ 50V		

Re-drying, if necessary, at 300°C for 2 hours. Guide electrode almost vertically with a short arc and a slight weave. Keep the welding current low to minimize dilution from the base material.

WELDING POSITIONS

EN ISO 6947: PA
ASME IX: 1G

PACKAGING

Electrode Ø x L [mm]	3.2 x 350	4.0 x 450	5.0 x 450
Weight/box [kg]	4.5	6	6

Other packaging and other sizes: please consult us