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| <b>Technical data sheet</b><br><br><small>011121MBA</small> | <b>Cored welding wire</b><br><br><b>HARDFACE L-G</b> |  |
|---|--|---|

### CLASSIFICATION

EN 14700: T Fe8

### DESCRIPTION

- Tubular wire for gas shielded metal arc hardfacing
- Martensitic weld metal with good abrasion and impact resistance
- Self-tempering deposit for hardfacing
- Especially applicable in 2-3 layers for wear resistance

### APPLICATIONS

HARDFACE L-G is used when good resistance to abrasion and impact in dry or wet environments is required.

#### Examples

Bucket teeth, lips and undersides, cutting edges, steel mill rolls, cable drums, sand dredge equipment, dragline buckets, conveyor chutes, grizzly bars

### TYPICAL ALL-WELD METAL ANALYSIS

| C   | Si  | Mn  | Cr  | Fe   |
|-----|-----|-----|-----|------|
| 0.5 | 2.4 | 1.7 | 8.5 | Bal. |

Structure: martensite

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit on mild steel: 56 – 60 HRC

### CONDITIONS OF USE

| Current type | Shielding gas |                                     |
|--------------|---------------|-------------------------------------|
| DC+          | EN ISO 14175  | M12: Ar + 0.5 – 5 % CO <sub>2</sub> |
|              |               | M13: Ar + 0.5 – 3% O <sub>2</sub>   |
|              |               | M21: Ar + 15 – 25 % CO <sub>2</sub> |

### OPERATING CONDITIONS

| Diameter [mm] | Current [A] |         | Voltage [V] |         | Stick-out [mm] |         |
|---------------|-------------|---------|-------------|---------|----------------|---------|
|               | Range       | Optimum | Range       | Optimum | Range          | Optimum |
| 1.2           | 100 – 300   | 220     | 16 – 32     | 28      | 12 – 25        | 15      |
| 1.6           | 150 – 300   | 250     | 16 – 32     | 29      | 12 – 25        | 20      |
| 2.0           | 200 – 400   | 300     | 25 – 32     | 29      | 12 – 30        | 25      |
| 2.4           | 250 – 450   | 350     | 25 – 32     | 29      | 12 – 30        | 25      |

Recovery: 95 %

### WELDING POSITIONS

HARDFACE L-G, up to Ø 1.6 mm, is suitable for positional welding as well as for downhand welding by adapting transfer mode and welding parameters as for solid wires.

### 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.