

Seamless metal cored wire for hardfacing

CLASSIFICATION

EN ISO 14700 (T Z Fe2)

GENERAL DESCRIPTION

Copper plated, seamless metal cored wire for hardfacing (55 - 65 HRC)

Well suited for wear resisting parts subject to heavy impact and shock. Very high resistance to wear caused by the abrasive action of minerals, clay, sand, gravel, and so on.

The molten pool is easily controlled, the beads are smooth. The absence of slag allows welding in several layers, without the necessity to remove the slag.

The deposited metal is crack-resistant, also after several layers.

TYPICAL USE

Mechanical shovels, bulldozers, scrapers, crushing hammers, bucket and loader teeth, conveyors, crusher jaws, crusher cones, etc.

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

C	Mn	Si	Cr	Mo	Fe	
0.50 - 0.70	1.40 - 1.80	0.30 - 0.70	6.00 - 8.00	0.40 - 0.70	Balance	

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
NPD	NPD	NPD	NPD

General information

Welding positions: All

Shielding gas: Ar/CO₂, M21 (EN ISO 14175)

Dia (x length) (mm): 1.2 - 1.6

Packing: 16 kg spool (in cardboard box)

Polarity: NA

Tips & tricks: Standard wire feed rolls suffice for feeding this wire without problems.
Mixed gas Ar-CO₂ about 12 litres a minute.
The interpass temperature should be maximum 250 °C.
The weld metal requires no buffer layer except on materials considered critical.
In this situation, Lastifil 20TB or LF8070 is to be used as a buffer.
The weld metal is machinable by carbide tools, hardening is possible.

The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.