


Technical data sheet <small>011121MBA</small>	Cored welding wire HARDFACE L-O	
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CLASSIFICATION

EN 14700: T Fe8

DESCRIPTION

- Tubular wire for self-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-O 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	Mn	Si	Cr	Fe
0.50	1.50	2.50	8.50	Bal.

Structure: medium alloy martensitic

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-Layer deposit

as welded: 56 - 59 HRc

CONDITIONS OF USE

Current type	Shielding
DC+	Self-shielded

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	100 - 300	250	21 - 35	28	12 - 25	20
1.6	150 - 300	270	24 - 35	28	15 - 25	25
2.0	200 - 400	300	26 - 35	28	20 - 50	30
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.