Technical data sheet 050122MBA	Cored welding wire # HARDFACE CNV-O	Welding Alloys

CLASSIFICATION

EN 14700: T Fe16

DESCRIPTION

- Tubular wire for self-shielded metal arc hardfacing
- High chromium cast iron with alloying additions giving a high concentration of complex carbides
- Resists extreme conditions of abrasion and temperature up to 700°C

APPLICATIONS

HARDFACE CNV-O is designed to give a weld deposit of particularly high hardness and wear resistance on account of the dispersion of hard complex carbides it contains. This gives superior performance compared to standard chromium cast irons. Optimum properties are reached in three layers. Relief checking is normal.

Examples

Ore sintering, crushing, riddling, blast furnace hoppers and throats, extractor fans etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Nb	Mo	W	V
5.5	0.5	1.5	22	6	5.5	2	1

Structure: hexagonal primary and eutectic carbides, nodular niobium carbides and complex combined carbides in an austenitic matrix.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit on mild steel: 65 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
1.2	100 - 300	160	24 - 30	28	25 - 50	25
1.6	150 - 350	250	24 - 30	28	25 - 50	25
2.0	200 - 400	300	26 - 30	28	25 - 50	35
2.4	250 - 450	350	26 - 30	28	25 - 50	40
2.8	250 - 450	400	28 - 32	30	25 - 50	40
3.2	250 - 500	450	28 - 32	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