

Technical data sheet

080122MBA

Cored welding wire

HARDFACE TIC-O**CLASSIFICATION**

EN 14700: T Fe8

DESCRIPTION

- Tubular wire for self shielded metal arc hardfacing
- Special chromium-titanium-molybdenum alloy designed for hardfacing components subject to severe abrasion and heavy impact
- The weld deposit contains extremely hard titanium carbide particles in a high chromium martensitic matrix

APPLICATIONS

HARDFACE TIC-O is ideal for excellent resistance to heavy impact, gouging and grinding abrasion. Some relief checking is normal but can be minimised by suitable preheat. It may be applied in multiple layers on massive pieces.

Examples

Augers, scraper blades, mixer tyres, brick dies, hammers, earthmoving equipment, crushing equipment, mining equipment, shovel buckets, slurry pipes, cane knives and shredders

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	Ni	Ti	V
2	1.2	1.2	7.3	1.2	1	5.5	0.2

Structure: martensite with dispersed titanium carbide particles

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit on mild steel: 57 – 60 HRc

CONDITIONS OF USE

Current type	Protection
DC- preferably, 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	25 - 50	25
1.6	150 - 350	270	24 - 35	28	25 - 50	25
2.0	200 - 400	300	26 - 35	28	25 - 50	35
2.4	250 - 450	350	26 - 35	28	25 - 50	40
2.8	250 - 450	400	28 - 35	30	25 - 50	40

Recovery: 85 %

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.