


<b>Technical data sheet</b>  011121MBA	<p style="text-align: center;">Coated SMAW Electrode</p> <h1 style="text-align: center;">WA HARDFACE HCNB-E</h1>	
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### CLASSIFICATION

EN 14700: E Fe15

### DESCRIPTION

- High recovery (230%) basic coated electrode
- Chromium cast iron deposit containing additional carbide-forming elements for increased service life (up to five times)
- Gives a smooth, virtually slag free deposit
- Highly resistant to mineral abrasion with moderate impact
- Relief cracks are normal

### APPLICATIONS

Endless screws, mixer paddles, pump bodies for abrasive materials and cement, excavator bucket teeth, screws, moulds and dies for brick making

### TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Si	Cr	Nb	Others	Fe
5	1	28	2.7	3	Bal.

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: ~64 HRC, obtained in one layer

### OPERATING CONDITIONS

Electrode Ø x L [mm]	3.2 x 350	4.0 x 450
Current [A]	140	180
= +	~ 70V	

Re-drying, if necessary, at 250°C for 1 hour. Maintain a short arc and hold the electrode nearly vertical. To minimise dilution with the base metal, select the lowest current that gives a stable arc and weave only slightly. Weld single layers, maximum two layers.

### WELDING POSITIONS

EN ISO 6947: PA  
ASME IX: 1G

### PACKAGING

Electrode Ø x L [mm]	3.2 x 350	4.0 x 450
Weight/box [kg]	5	6.5

Other packaging and other sizes: please consult us