

<b>Technical data sheet</b>  <small>011121MBA</small>	<b>Tubular SMAW Electrode</b>  <b>WA HARDFACE HC-TE</b>	 <b>Welding Alloys</b>
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#### CLASSIFICATION

EN 14700: T Fe15

#### DESCRIPTION

- High chromium cast iron for hardfacing components subjected to extremely severe abrasive wear and moderate impact.
- The deposit contains a high proportion of hard primary chromium carbides in a tough austenitic matrix.

#### APPLICATIONS

- Typical applications include palm oil extruders, screw conveyors, gyratory crusher cones and mantles, dredge pump bodies, mining and earth moving equipment, agricultural equipment, wear plates, sugar mill crusher hammers, drag line components, quarry and sand handling equipment, brick manufacturing equipment etc.

#### TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Cr
5.5	1.5	35

Structure: chromium carbides in an austenitic matrix.

#### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

All-weld metal: 61 HRc

#### CONDITIONS OF USE

Electrode Ø x L (mm)	6.0 x 450	8.00 x 450	12.0 x 450
Current (A)	85 -135	130 -190	200 - 430

Polarity: AC or DC

#### WELDING POSITIONS

Flat, half up and half down.

#### PACKAGING

Electrode Ø x L (mm)	Quantity	Weight [kg]
6.0 x 450	~ 61	4 x 5.0
8.0 x 450	~ 36	4 x 5.0
12.0 x 450	~ 17	4 x 5.0

Other packaging and other sizes: please consult us

#### TIP COLOUR IDENTIFICATION

- Blue