

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

EN 14700: T ZFe1

DESCRIPTION

- Low alloy tubular wire for self shielded metal arc hardfacing
- Used for the repair of rails
- Gives a bainitic deposit with a useful combination of strength, toughness and wear resistance. The microstructure is practically unaffected by dilution and remains uniform throughout the deposit.
- Welded under positive polarity, the wire deposits clean beads without spatter and with good penetration and slag removal

APPLICATIONS

HARDFACE TN-O is used for repair of pearlitic steels typically containing 0.5 - 0.8% carbon.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	Fe
0.09	1.5	0.7	0.3	2.1	0.5	Bal.

Structure: bainite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

The hardness of undiluted weld metal: 30 - 35 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
1.6	140 – 350	150	24 – 28	24	25 – 30	25
2.0	200 – 400	250	26 – 30	26	25 – 40	35
2.4	250 – 450	300	26 – 30	28	25 – 40	35

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.