


|  |  |   |
|--|--|---|
| <b>Technical data sheet</b><br><br><small>EN180722</small> | <b>Tubular SMAW Electrode</b><br><br><b>WA HARDFACE CNV-TE</b> |  <b>Welding Alloys</b> |
|--|--|---|

### CLASSIFICATION

EN 14700: TFe16 - C6Cr20Nb6Mo5W2V1-65

### DESCRIPTION

- High chromium cast iron with extra alloying additions for hardfacing of components subject to extremely severe abrasive wear at high temperatures
- The deposit contains a high proportion of hard primary and secondary chromium and complex carbides in a tough austenitic-martensitic matrix
- The alloy maintains its abrasive resistance up to 650°C

### APPLICATIONS

- Typical applications include boiler components, high temperature components of process industry such as sinter plant or blast furnace components etc.

### TYPICAL ALL-WELD METAL ANALYSIS

| C   | Mn  | Si  | Cr   | Mo  | Nb  | V   | W   | Fe  |
|-----|-----|-----|------|-----|-----|-----|-----|-----|
| 6.0 | 1.0 | 0.9 | 20.0 | 5.0 | 6.0 | 1.2 | 1.5 | Bal |

Structure: Heat-resistant complex alloy carbides in an austenitic-martensitic matrix.

### TYPICAL MECHANICAL PROPERTIES

Typical hardness (3 layers): 65 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

| Diameter x length [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     |

### TYPICAL COVERAGE (APPROX) IN KG PER SQUARE M X 3MM HIGH

| Diameter x length [mm] | Weight [kg] |
|------------------------|-------------|
| 6.0 x 450              | 30          |
| 8.0 x 450              | 30          |
| 12.0 x 450             | 30          |

### TIP COLOUR IDENTIFICATION

- White

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.