


Technical data sheet <small>011121MBA</small>	Coated SMAW Electrode WA HARDFACE CNV-E	 Welding Alloys
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CLASSIFICATION

EN 14700: E Fe16

DESCRIPTION

- Basic coated SMAW electrode for hardfacing
- High chromium cast iron with extra alloying additions for hardfacing components subject to extremely severe abrasive wear at high temperatures
- The deposit contains a high proportion of hard primary chromium and complex carbides in a tough secondary carbide eutectic matrix
- Maintains its abrasion resistance up to 600°C
- Recovery: 200%

APPLICATIONS

WA HARDFACE CNV-E is designed to give a weld deposit of particularly high hardness and wear resistance on account of the dispersion of complex carbides it contains. This gives superior performance compared to standard chromium cast irons. Relief checking is normal.

Examples

Ore sintering, crushing, riddling, blast furnace hoppers and throats, screw conveyors, manufacture of cement and ceramics.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	Nb	W	V
5.5	0.3	1.5	22	7	7	2	1

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit on mild steel: 65 HRC

Machinability: by grinding

OPERATING CONDITIONS

Electrode Ø x L [mm]	3.2 x 350	4.0 x 450	5.0 x 450
Current [A]	110 - 140	140 - 190	190 - 250
= +	~ 50V		

Re-drying, if necessary, 2h at 300°C.

Guide electrode almost vertically with a short arc and a slight weave. Keep the welding current low to minimize dilution from the base material.

WELDING POSITIONS

EN ISO 6947: PA

ASME IX: 1G

PACKAGING

Electrode Ø x L [mm]	3.2 x 350	4.0 x 450	5.0 x 450
Weight/box [kg]	4.5	6	6

Other packaging and other sizes: please consult us