



740

EN 14700 T Fe1

DESCRIPTION

Seamless high fill copper coated tubular wire for semi-automatic gas shielded hardfacing. It is used for rebuilding of worn hardened steel parts subject to high compressive stresses and heavy impacts. It can also be used as a buffer layer on ferritic steels before hardfacing with wires providing higher abrasion resistance. Designed for welding in horizontal, horizontal-vertical and vertical-up positions. Typical applications: Transmission shafts, gear teeth, conveyor chains, wheels of rolling bridges, bearing tracks, forgings and dies etc.

WELDING POSITIONS



CURRENT

DC+
(DC-)

GAS

M21
M12

MECHANICAL PROPERTIES

Hardness

42 HRC

WELD METAL COMPOSITION(%)

C	Si	Mn	Cr	Ni	Mo
0,15	0,8	1,8	3	-	0,4

PACKAGING AND WELDING PARAMETERS

Dimension(mm)	1,2	1,6		
Spolstorlek(kg)	15	15		
Current(A)	110-300	130-350		
Voltage(V)	16-32	16-32		
Stick out(mm)	12-25	12-25		
Gas flow (l/min)	10-20	10-20		