

HARDFACE T-O/S/G

Welding Wire



Welding Alloys Group

Products manufactured and sold
in over thirty countries worldwide

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CLASSIFICATIONS

AS2576-1982, 1435-B7, B1, B5

WTIA (TN4), 1435-B7, B1, B5

DESCRIPTION

Hardface T is a cored wire used for hardfacing and rebuilding components subject to metal - metal wear and moderate abrasion. The weld deposit is typical of a low alloy steel and is used for heavy multi-layer build-up work. The weld deposit is machinable.

T-O - Open Arc (Self Shielded - Gasless) Wire

T-S - Submerged Arc Wire

T-G - Gas Shielded Wire

TYPICAL APPLICATIONS

Build up of earthmoving equipment such as tractor rollers, idlers, chains and drive sprockets, excavator pads, electric shovel track pads, electric shovel track carrier rolls, steel shafts, trunnions, gears, crane wheels, mine car wheels, steel mill rolls, dredge pins, dredge links, mixer parts, rail car couplings, steel mill roll couplings and any components subject to metal - metal wear.

TYPICAL CHEMICAL COMPOSITION

C - 0.14%, Mn - 1.5%, Si - 0.5%, Cr - 1.6%, Mo - 0.35%

TYPICAL HARDNESS

30 - 35 HRC

295 - 335 HB

AVAILABLE SIZES

1.2mm, 1.6mm, 2.0mm, 2.4mm, 2.8mm, 3.2mm

WELDING PARAMETERS**Open Arc (Self Shielded - Gasless)**

Wire Diameter	Current (Amps)		Voltage (Volts)		Stick-out (mm)		Polarity
	Range	Optimum	Range	Optimum	Range	Optimum	
1.6mm	150-350	270	24-28	24	25-50	25	DC+
2.0mm	200-400	300	26-30	26	25-50	35	DC+
2.4mm	250-450	350	26-30	28	25-50	40	DC+
2.8mm	250-450	400	28-32	30	25-50	40	DC+

No gas required

Submerged Arc

Wire Diameter	Current (Amps)		Voltage (Volts)		Stick-out (mm)		Polarity
	Range	Optimum	Range	Optimum	Range	Optimum	
2.4mm	200-450	350	26-30	30	25-60	30	DC+
2.8mm	250-550	400	28-32	30	25-60	30	DC+
3.2mm	300-650	500	28-32	30	25-60	30	DC+

Use with neutral agglomerated flux, eg, WAF 325, WAF 350

Gas Shielded

Wire Diameter	Current (Amps)		Voltage (Volts)		Stick-out (mm)		Polarity
	Range	Optimum	Range	Optimum	Range	Optimum	
1.2mm	100-280	220	18-30	22	15-25	20	DC+
1.6mm	150-350	300	22-30	26	15-25	20	DC+

Use with Argon + 15-20% CO₂ gas - Flow rate 15-20 litres/minute

Our products, and any recommended practices, should be tested by the user under actual service conditions to determine their suitability for any particular purpose. The results obtained using this product/information are affected by variables such as welding procedure, base material composition, operating temperature, weldment design, method of fabrication and service requirements which are beyond our control. It is the sole responsibility of the user to determine the serviceability of a structure using this product and the information contained in this data sheet.