PROLINE
professional welding supplies

HARDFACE L-O/S/G

Welding Wire

Welding Alloys Group
Products manufactured and sold
in over thirty countries worldwide

CLASSIFICATIONS

AS2576-1982, 1855-B7, B1, B5
WTIA (TN4), 1855-B7, B1, B5

DESCRIPTION

Hardface L is a cored wire used for hardfacing components subject to metal -metal wear and high abrasion. The weld deposit has good impact resistance and high hardness. The weldmetal is a medium alloy Martensitic steel. It is an economical wire with good abrasion and impact resistance.

The weld deposit is just machinable with special tools.

L-O - Open Arc (Self Shielded - Gasless) Wire
L-S - Submerged Arc Wire
L-G - Gas Shielded Wire

TYPICAL APPLICATIONS

Ball mill rolls, bucket teeth, bucket lips, bucket undersides, cutting edges, steel mill rolls, cable drums, blast furnace bells, sand dredge equipment, dragline buckets, conveyor chutes, grizzly bars. Especially applicable in 2-3 layers for wear resistance.

Pre-heat should be applied to prevent relief checking.

TYPICAL CHEMICAL COMPOSITION

C - 0.50%, Mn - 2.5%, Si - 0.8%, Cr - 8.0%, Mo - 0.6%, V - 0.3%

TYPICAL HARDNESS

55 - 60 HRC
520 - 578 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	300-550	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% CO_2 gas - Flow rate 15-20 litres/minute