

## HARDFACE LP-G

### Welding Wire



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

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#### CLASSIFICATIONS

**AS2576**    **WTIA (TN4)**  
**1855-B5**    **1855-B5**

#### PRODUCT NAME

**LP-G**

#### WELDING PROCESS

**Gas Shielded**

#### DESCRIPTION

**Hardface LP-G** is a genuine **all-positional** cored wire used for hardfacing components subject to metal-metal wear, impact and high abrasion. The wire has been specifically developed to operate in the spray transfer mode whilst welding in all positions. This economical welding wire will produce a medium alloy Martensitic steel weldmetal with good abrasion and impact resistance. The completed weld bead will have a very smooth and even contour with no spatter.

The weld deposit is just machinable with special tools.

#### TYPICAL APPLICATIONS

This wire has many applications where moderate/high impact and high abrasion wear conditions prevail. Bucket teeth, bucket lips, bucket sides, cutting edges, sand dredge equipment, dragline buckets, conveyor chutes, grizzly bars, screw flights, metal shredders. **Especially applicable for all-positional welding and re-instating of hardfacing sealing runs on clad wear plate fabrications.**

Pre-heat should be applied to prevent relief checking.

#### TYPICAL CHEMICAL COMPOSITION

C - 0.50%, Mn - 1.8%, Si - 1.3%,  
Cr - 7.5%, Mo - 0.5%, V - 0.3%  
Fe - Balance

#### TYPICAL HARDNESS

55 - 60 HRC  
520 - 578 HB

**AVAILABLE SIZES**

1.2mm, 1.6mm.

**WELDING PARAMETERS**

Wire Diameter	Current (Amps)		Voltage (Volts)		Stick-out (mm)		Polarity
	Range	Optimum	Range	Optimum	Range	Optimum	
1.2mm	100-280	220	18-30	27	15-25	20	DC+
1.6mm	150-350	300	22-30	30	15-25	20	DC+

Use with CO<sub>2</sub> or Argon + 15-25% CO<sub>2</sub> shielding gases - 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.

DSHF:LP-G REV: 01 05/2005