




HARDFACE L-E

Manual Arc Electrode

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CLASSIFICATION	AS 2576, 1855-A4 WTIA(TN4), 1855-A4 EN 14700, T Fe8
DESCRIPTION	HARDFACE L-E is a basic electrode producing a medium alloy, air hardening martensitic steel deposit that is tough, hard and has good abrasion and impact resistance. Weld metal has good crack resistance. The basic coating provides tolerance to rust and mill scale on the surface to be welded.
APPLICATIONS	Suitable for hardfacing mild steel, carbon steel and alloy steel components subject to metal to metal wear, impact and high abrasion. Typical applications are; bucket teeth, bucket lips, slides, conveyor shutes, cutting edges, tracked vehicle tracks and rollers, bucket undersides, grizzly bars, sand dredging equipment, cable drums and pulleys.
ALL WELD METAL PROPERTIES (TYPICAL)	Chemical (Wt%) : C Mn S Cr Fe 0.50 0.60 2.00 9.5 Bal: Hardness 58 HRC (3 layers, as-welded) Hardness 650 HV (3 layers, as-welded)

<p>WELDING PARAMETERS</p>	<p>HARDFACE L-E</p>  <table border="1" data-bbox="472 453 883 621"> <thead> <tr> <th>Size (mm)</th> <th>Polarity</th> <th>Amperage (Amps)</th> </tr> </thead> <tbody> <tr> <td>3.2 x 350</td> <td>DC+</td> <td>90-120</td> </tr> <tr> <td>4.0 x 450</td> <td>DC+</td> <td>110-160</td> </tr> </tbody> </table>	Size (mm)	Polarity	Amperage (Amps)	3.2 x 350	DC+	90-120	4.0 x 450	DC+	110-160			
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<p>PACKAGING</p>	<table border="1" data-bbox="472 751 1024 915"> <thead> <tr> <th>Size (mm)</th> <th>Carton Kg</th> <th>Canister Kg</th> <th>Rods per Packet</th> </tr> </thead> <tbody> <tr> <td>3.2 x 350</td> <td>15</td> <td>5</td> <td>152</td> </tr> <tr> <td>4.0 x 450</td> <td>19.5</td> <td>6.5</td> <td>96</td> </tr> </tbody> </table>	Size (mm)	Carton Kg	Canister Kg	Rods per Packet	3.2 x 350	15	5	152	4.0 x 450	19.5	6.5	96
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<p>ADDITIONAL INFORMATION</p>	<p>Preheat may be necessary to prevent relief checking and cracking. If deposited on high alloy or crack sensitive material a buffer layer of TETRA 309L-E is recommended.</p>												

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.

DS:HFLE

REV: 01 (RW/PS/HB)

01/14