

## Hardface HC40-TE

Tubular Manual Arc Electrode



**Welding Alloys Group**

Products manufactured and sold  
in over thirty countries worldwide

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### CLASSIFICATION

AS 2576: 2360-A1

EN 14700: T-Fe14-C6Cr40-62

### DESCRIPTION

**Hardface HC40-TE** is a tubular coated, manual arc electrode for the hardfacing of components subject to severe abrasion and low/moderate impact. The weld deposit contains a high proportion of hard primary Chromium carbides in a tough Austenitic matrix. The deposit is non machinable.

### TYPICAL APPLICATIONS

Gyratory cones and mantles, catalyst pipes and valves, slurry pipes and valve bodies, alluvial dredging components such as pump casings and teeth, sand dredge parts, extruder screws, "barmac" crushers, mining and earth moving components, dragline components, manufacture and repair of clad wearplate, blast furnace bells, coke hammers, coal pulveriser rolls, brick muller tyres, sugar cane harvester machine and crushing components such as base cutter discs, knives, rolls, scraper plates and shredders.

### TYPICAL ALL WELD METAL PROPERTIES

<b>Chemical (Wt %):</b>	<u>C</u>	<u>Mn</u>	<u>Si</u>	<u>Cr</u>	<u>Fe</u>
	6.5	0.8	0.8	40.0	Bal.

Micro-structure: High carbide volume fraction of Primary Chromium carbides in a tough secondary carbide/Austenite eutectic matrix.

### **Hardness**

Single Layer: 55-60 HRC

3 Layer Deposit: 58-62 HRC

Relief checking is normal

**WELDING PARAMETER GUIDELINES****6 mm Electrodes****8 mm , 12mm Electrodes**

Polarity:- AC or DC+

Electrode Dia, Length (mm)	6.0 x 450	8.0 x 450	12 .x.450
Welding Current (A)	85-135	130-190	200-430

**PACKAGING**

Diameter x Length (mm)	Quantity #	Weight (kg)
6.0 x 450	61	5.0
8.0 x 450	36	5.0
12.0 x 450	17	5.0

#Electrodes are packed by weight, quantity is approximate.

**TIP COLOUR IDENTIFICATION**

Tip colour at the electrode holder end is BLACK

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: HARDFACE HC40-TE

REV:00(RW)

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