

- ▲ **Self Shielded (-0), Tubular Hardfacing Wire.**
- ▲ **Air Hardening, Crack Prone High Carbon, Martensitic Steel Deposit.**
- ▲ **Resistant to Severe Abrasion and Low Impact Loading.**
- ▲ **typical applications include the hard surfacing of agricultural, mining and materials handling equipment including tynes, points, conveyor screws, dredge buckets, cane harvester cutters/elevators and sugar mill scraper plates.**
- ▲ **1.2mm size can be used for vertical surfacing by depositing overlapping horizontal stringer passes.**

Classifications:

CO2 GAS Shielded hardfacing wire 1.2mm & 1.6mm

TYPICAL ALL WELD METAL DEPOSIT ANALYSIS:

C:0.5-1.5%	Mn:0.3-1.5%	Si: 0.5-1.5%
Cr:5.5-7.5%	Mo: 3.0-4.5%	B:

TYPICAL WELD DEPOSIT HARDNESS:

	HRC	HV30
Single Layer on Mild Steel	60-64	≥700
All Weld Metal Deposit	62-69	≥750

FINISHING RECOMMENDATIONS:

Grinding only.

RECOMMENDED SHIELDING GAS:

- Open arc or welding grade CO2
- ISO9001:2015

Downhand & Horizontal surfacing applications:- 1.2mm size can be used for vertical surfacing by depositing overlapping horizontal stringer passes.

Description and Applications:

It is a self shielded (or open arc) hard surfacing wire which deposits a high carbon martensitic steel for excellent resistance to severe, fine (wet or dry) abrasion and low impact loading.

Weld deposits are air hardening and prone to fine relief checking. should not be used in applications involving heavy impact or shock loading. 1.2mm wire is ideal for all positional surfacing applications with the Transmig 250 and 275 power plant.

Typical applications include the hard surfacing of agricultural, mining and materials handling equipment including tynes, points, conveyor screws, dredge buckets, cane harvester cutters / elevators and sugar mill scraper plates.

Packaging and Operating Data:

DC Electrode Positive

Wire Dia mm	Current Range (amps)	Voltage Range (volts)	Recommended Stickout (ESO) mm	Pack Type	Pack Weight	Part No
1.2	120-220	18-24	15-20	Spool	15kg	11945500