HARDCOR 660 O

Standards

TS EN 14700	: T Fe9
EN 14700	: T Fe9
DIN 8555	: - MF 7-GF-200 KP

Chemical Composition of Weld Metal (Typical)

C	Si	Mn	Cr	Fe
0.40	0.75	15.0	15.0	Rest

Mechanical Properties

Hardness	
(As Welded) (HRC)	(After Working) (HRC)
18 - 24	45 - 52

Typical Base Material Grades

- Manganese rock crushing hammers and rolls, impactor bars, gyratory mantles, dredge components

Features and Applications

- Applicability in buffer layer and surfacing of carbon- and mangenese-steels
- High resistance to impact and friction
- Most common applications in hardfacing of various aquipment parts that are exposed to deep impacts, pressure and wearing in cement, mining and earth-moving industries
- Build up death is generally unlimitted. Weld metal hardness increases by work hardening
- Shielding Gas: Open Arc

Resistance Type and Level

Friction ■□□□
High Temp. ■□□□
Corrosive ■■■□
Machining ■■□□
Impact ■■■■
Thermo Shock ■□□□
Crack Resistance ■■■■

Operating Data

Diameter (mm)	Welding Current (A)	Voltage (V)	Stick-out (mm)
1.60	130 - 220	26.0 - 31.0	25.0 - 30.0
2.80	300 - 500	25.0 - 31.0	25.0 - 30.0

Current Type

FCAW / D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
6031100379	1.60	1/16	15
6031100380	2.80	7/64	25

Approvals: SEPRO