Technical Data Sheet

HARDFACE TIC-O

Highly alloyed steel with hard phases -> Cored wire for Self-shielded Flux Cored Arc Welding (FCAW-S)

1 GENERAL INFORMATION

EN 14700 : T Fe8

- Finely dispersed titanium and chromium carbides in a martensitic matrix deposit
- Dedicated to hardfacing of components subject to extreme abrasion, high pressure and heavy impact
- Excellent resistance to heavy impact, gouging and grinding abrasion
- Some relief checking is normal but can be minimised with suitable preheating
- Can be applied in multiple layers on large parts

Augers, scraper blades, mixer tyres, brick dies, hammers, earthmoving equipment, crushing equipment, mining equipment, shovel buckets, slurry pipes, cane knives, shredders, etc.

2 ALL WELD METAL PROPERTIES

CHEMICAL ANALYSIS [%]

C	Mn	Si	Cr	Mo	Ti	V
2.1	1.2	1.2	7.4	1.3	5.6	0.2

HARDNESS

53-60 HRC (as welded, three-layers)

3 RECOMMENDED WELDING PARAMETERS

Diameter [mm]	Welding Position	Polarity	Current [A]	Voltage [V]	Stick-out [mm]
1.2	PA / 1G or 1F	DC+	200 - 300	26 - 30	25 ± 5
1.6	PA / 1G or 1F	DC+	220 - 320	26 - 30	25 ± 5
2.0	PA / 1G or 1F	DC+	250 - 350	26 - 30	30 ± 5
2.4	PA / 1G or 1F	DC+	300 - 400	26 - 30	35 ± 5
2.8	PA / 1G or 1F	DC+	350 - 450	28 - 32	40 ± 5

WELDING PROTECTION

Self-shielded

WELDING POSITION

YouTube TUTORIAL VIDEO

Video Link

4 PACKAGING OPTIONS

Diameter [mm]	1.2 - 1.6	2.4 - 2.8	2.4 - 2.8
Standard packaging (EN ISO 544)	BS 300 spool	B 450 coil	Drum
Weight [kg]	15	25	Up to 330

Other packaging requirements: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.