WEARcore XD 70-O (SK ABRA-MAX O/G)

self-shielded core wire

Classifications

<table>
<thead>
<tr>
<th>EN 14700</th>
<th>DIN 8555</th>
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<tbody>
<tr>
<td>T Z Fe8</td>
<td>MF 6-GF-70-GT</td>
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</table>

Characteristics

Special hardfacing cored wire designed to give an extreme resistance against high-stress-grinding abrasion and erosion without impact. The typical mechanical properties can be achieved in the first layer. The deposit will readily show stress relief cracks.

- **Microstructure:** Complex carbo-borides and borides homogeneously dispersed in the matrix
- **Machinability:** Grinding only
- **Oxy-acetylene cutting:** Cannot be flame cut
- **Deposit thickness:** ca. 8 mm in maximum 2 layers
- **Shielding gas:** Argon + 2% Oxygen (if not used as open arc)

Field of use

Conveyors screws, crusher plates and rolls, shredder teeth, fan blades, bucket teeth and lips, agricultural machinery, wear plates, etc.

Typical analysis in %

C + Cr + Mo + Nb + W + V + B (Bal Fe)

Typical mechanical properties

Hardness as welded: 70 HRC

Recommended welding parameters

<table>
<thead>
<tr>
<th>Wire diameter [mm]</th>
<th>Amperage [A]</th>
<th>Voltage [V]</th>
<th>Stick-Out [mm]</th>
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</thead>
<tbody>
<tr>
<td>1.2</td>
<td>130-180</td>
<td>22-26</td>
<td>15-25</td>
</tr>
<tr>
<td>1.6</td>
<td>180-230</td>
<td>26-30</td>
<td>20-35</td>
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