

Classifications									
EN14700									
T Z Fe1									
Characteristics and typical fields of application									
<ul style="list-style-type: none"> • Rebuilding and hardfacing of Carbon steel parts. • Crawler tractor rollers and idlers and idlers, shafts, cylinders, mine car wheels, crane wheels... 									
Typical analysis of all-weld metal									
C	Si	Mn	Cr	Mo					
0.15	-	1.0	2.0	0.5					
Mechanical properties of all-weld metal – typical values (min. values)									
	PWHT	Shield gas	As Welded	Work-hardened					
	(°C/h)		(HB)	(HB)					
Typical	-	-	420≈HRC43	-					
Guarantee	-	-	360-450	-					
General Characteristics									
Microstructure	Machinability	Oxyacetylene cutting	Deposit thickness	Shield gas					
Bainite+ Martensite	Good	Possible	Depends upon application and procedure used	-					
Operating Data									
Dia.(mm)	Current(A)	Voltage(V)	Stick-out(mm)						
2.8	300-350	26-30	35-40						