

Classifications									
EN14700									
T Fe10									
Characteristics and typical fields of application									
<ul style="list-style-type: none">•Self-shielded flux cored wire.•Austenitic alloy type 18CrNiMo designed for joining dissimilar metals and for buffer layer deposits prior to hardfacing. Joining of wear plates on shovel buckets, rebuilding of rails, press rams. Repairing for 14%Mn steel parts, colours of weld metal same as 14%Mn steels base metal. <ul style="list-style-type: none">•Used for crusher roller, crusher hammer, bucket teeth and lip.									
Typical analysis of all-weld metal									
C	Si	Mn	Cr	Ni					
0.1		7.0	19.0	9.0					
Mechanical properties of all-weld metal – typical values (min. values)									
	PWHT		Shield gas		As Welded		Work-hardened		
	(°C/h)				(HRC)		(HRC)		
Typical					180				
Guarantee					180-200				
General Characteristics									
Microstructure		Machinability		Oxyacetylene cutting		Deposit thickness		Shield gas	
Austenite		Good with carbide tipped tools		Not Possible		Depends upon application and procedure used			
Operating Date									
Dia.(mm)		Current(A)		Voltage(V)		Stick-out(mm)			
2.8		300-350		26-30		35-40			