

Classifications									
EN14700									
T Fe9									
Characteristics and typical fields of application									
<ul style="list-style-type: none">•Self-shielded flux cored wire.•Austenitic alloy type for hardfacing and welding.•Rebuilding and joining of carbon and14%Mn steel, buffer layer prior to hardfacing. Used for railway rails and crossovers, mill shaft drive ends, gyratory crusher mantles, repointing of shovel teeth.									
Typical analysis of all-weld metal									
C	Si	Mn	Cr	Ni					
0.5	0.5	16.0	13.0	0.5					
Mechanical properties of all-weld metal – typical values (min. values)									
	PWHT		Shield gas		As Welded		Work-hardened		
	(°C/h)				(HB)		(HB)		
Typical					210		50		
Guarantee					200-250		50-55		
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			