

Classifications									
EN14700									
T Z Fe1									
Characteristics and typical fields of application									
<ul style="list-style-type: none"> <li>• Rebuilding alloy for carbon steel parts.</li> <li>• Crawler tractor links, crane wheels, shafts, buffer layer for continuous rollers, mine car wheels...</li> </ul>									
Typical analysis of all-weld metal									
C	Si	Mn	Cr	Nb					
0.1	-	1.0	0.5	0.5					
Mechanical properties of all-weld metal – typical values (min. values)									
	PWHT	Shield gas	As Welded	Work-hardened					
	(°C/h)		(HRC)	(HRC)					
Typical	-	-	315	-					
Guarantee	-	-	275-325	-					
General Characteristics									
Microstructure	Machinability	Oxyacetylene cutting	Deposit thickness	Shield gas					
Bainite	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						