

# HARDFACE T-O/S/G

Welding Wire



**Welding Alloys Group**  
Products manufactured and sold  
in over thirty countries worldwide

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## CLASSIFICATIONS

AS2576-1982, 1435-B7, B1, B5  
WTIA (TN4), 1435-B7, B1, B5

## DESCRIPTION

**Hardface T** is a cored wire used for hardfacing and rebuilding components subject to metal - metal wear and moderate abrasion. The weld deposit is typical of a low alloy steel and is used for heavy multi-layer build-up work. The weld deposit is machinable.

- T-O - Open Arc (Self Shielded - Gasless) Wire
- T-S - Submerged Arc Wire
- T-G - Gas Shielded Wire

## TYPICAL APPLICATIONS

Build up of earthmoving equipment such as tractor rollers, idlers, chains and drive sprockets, excavator pads, electric shovel track pads, electric shovel track carrier rolls, steel shafts, trunnions, gears, crane wheels, mine car wheels, steel mill rolls, dredge pins, dredge links, mixer parts, rail car couplings, steel mill roll couplings and any components subject to metal - metal wear.

## TYPICAL CHEMICAL COMPOSITION

C - 0.14%, Mn - 1.5%, Si - 0.5%, Cr - 1.6%, Mo - 0.35%

## TYPICAL HARDNESS

30 - 35 HRC  
295 - 335 HB

## AVAILABLE SIZES

1.2mm, 1.6mm, 2.0mm, 2.4mm, 2.8mm, 3.2mm

## WELDING PARAMETERS

### **Open Arc (Self Shielded - Gasless)**

Wire Diameter	Current (Amps)		Voltage (Volts)		Stick-out (mm)		Polarity
	Range	Optimum	Range	Optimum	Range	Optimum	
1.6mm	150-350	270	24-28	24	25-50	25	DC+
2.0mm	200-400	300	26-30	26	25-50	35	DC+
2.4mm	250-450	350	26-30	28	25-50	40	DC+
2.8mm	250-450	400	28-32	30	25-50	40	DC+

No gas required

### Submerged Arc

Wire	Current (Amps)		Voltage (Volts)		Stick-out (mm)		Polarity
Diameter	Range	Optimum	Range	Optimum	Range	Optimum	
2.4mm	200-450	350	26-30	30	25-60	30	DC+
2.8mm	250-550	400	28-32	30	25-60	30	DC+
3.2mm	300-650	500	28-32	30	25-60	30	DC+

Use with neutral agglomerated flux, eg, WAF 325, WAF 350

### Gas Shielded

Wire	Current (Amps)		Voltage (Volts)		Stick-out (mm)		Polarity
Diameter	Range	Optimum	Range	Optimum	Range	Optimum	
1.2mm	100-280	220	18-30	22	15-25	20	DC+
1.6mm	150-350	300	22-30	26	15-25	20	DC+

Use with Argon + 15-20% CO<sub>2</sub> gas - Flow rate 15-20 litres/minute