

GRADE

CLASSIFICATION FEATURES

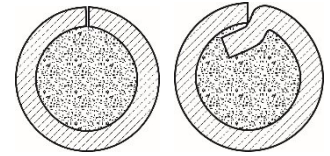
STRUCTURE TYPE

PP-Np-30H4G2M

(Np-30Cr4Mn2Mo)

TU U 28.7-21459234-021:2008

Diameter: 1.2 – 4.0 mm
 Shielding: open arc, flux
 Structure: tubular, overlapping



General description

Flux-cored wire of **PP-Np-30H4G2M** grade is designed for open-arc and submerged-arc hardfacing of parts exposed to metal-to-metal friction with extra alternating and impact loads. It is desirable to perform hardfacing down-hand, using reversed polarity direct current.

Welding process properties

- Recommended flux grade - **EFA-1**, AN-20S/P, AN-26S/P
- Weld formation - good
- Slag separation - good
- Deposit factor, g/A·h - 10 – 15
- Crack susceptibility - moderate
- Wire consumption per, kg - 1.05 – 1.2
- Hardness of weld metall - after hardfacing: **HRC 42 – 48**

Operating conditions (submerged-arc)

Wire diameter, mm	Current, A	Voltage, V	Deposition rate, m/h
1.6	140 – 200	27 – 28	10 – 14
2.0	180 – 240	28 – 29	12 – 17
2.4	220 – 280	29 – 30	15 – 19
2.8	250 – 330	30 – 31	18 – 22

Properties of weld metall

Wear resistance: increased. Impact resistance: satisfactory. Can be machined with cutting tools.

Process features

Hardfacing of carbon steel requires the part to be pre-heated to 200-300°C.
 Wire diameters up to 2.2 mm can be supplied on metal spools K-300 (15 kg).

Application

Hardfacing of tracked vehicle undercarriage wheels and rollers, rubber mixer chambers and augers, steel crankshafts, universal joint spiders, etc.

