

Typical Applications

- Suitable for cable rolls, rails, couplings.
- Shafts, crane wheels, buffer layer for continuous casting rollers
- Mine car wheels, track pads.
- Track pads, rails.

Standards

EN 14700 T Fe 6

General Characteristics

BaseHARD[®] 5100 is a flux cored wire developed for impact load, high pressure and moderate metal to metal wear. Suitable for buffer layers and rebuilding before hardfacing operations.

Weld metal is machinable and suitable for multi-layers.

Wear Resistance

Impact



Metal to Metal



Abrasion



Welding Positions, Polarity and Shielding Gases

Welding Positions : PA, PB, PC
Shielding Gas : Not Required
Polarity : DC (+)

Microstructure

Bainite.

Typical Mechanical Properties (All Weld Metal)

Heat Treatment	Welding Sequence	Hardness (HB)
As Welded	3. Layer	325

Packaging & Diameter Details

Product Code	Diameter (mm)	Packaging Options
-	1.20	
-	1.60	15 Kgs Spools (BS 300)
-	2.00	25 Kgs Spools (BS 450)
-	2.40	250/300 Kgs (Drums)
-	2.80	

Recommended Operating Parameters

Diameter	Current (A)	Voltage (V)
1.20	160 - 240	22-24
1.60	180 - 240	24-26
2.00	220 - 280	25-27
2.40	260 - 320	25-29
2.80	300 - 360	26-30

Storage Informations

Products should be stored in moisture free room on wooden, composit or plastic pallets.