



Solid Wire (MIG)

Impact Resistance (Hard Facing)

HW-1400

DESCRIPTION & APPLICATION

Solid, copper coated MIG wire for the overlay of all Carbon/Manganese steels and Austenitic 14% Manganese. Also suited for the overlay of Cast Iron (over Buffer layer). Main applications are Earth moving and mining equipment, hammers, percussion tools and components where the main wear factor is impact. Machineable with correct tooling and work hardenable.

BASE MATERIALS

All Carbon/Manganese steels, Hadfields Steel, Cast Iron (over buffer layer of Westbrook SW-55 or similar in Electrode form).

MECHANICAL PROPERTIES

N/A	N/A	N/A	350-400
UTS n/mm	YIELD 0.2%	ELONG A5%	HARDNESS HV

METAL WELD COMPOSITION %

C	Si	Mn	Cr	Cu	Mo
0.068	0.72	0.99	5.8	0.16	0.8

PACKAGING

15kg Spools (MIG)

DIAMETERS

1.0, 1.2mm (MIG)

WELDING INSTRUCTIONS

Preheat as per the requirements of the base material. Large deposits may require a buffer layer of SW 312 or SW 307 to avoid cracking. Do not pre-heat Austenitic Manganese. Shielding Gas 5% or 20% CO₂ in Argon.

For more details on welding of Hard-facing, please see our Information Sheets.
Visit: www.westbrookwelding.co.uk/downloads