



**Chandraprabhu Enterprise Private Limited**

## **HARDFACING WELDING WIRES**

**Name: CEPL-5414**

<b>Weld metal chemistry</b>	<b>C = 0.04%, Cr = 12.50%, Mn = 1.30%, Mo = 0.40%, Si = 0.70%, N = 0.12%, Ni = 4.00%</b>	
<b>Hardness (3 layers)</b>	<b>40–44 HRC</b>	
<b>Size</b>	<b>1.60mm, 2.00mm, 2.40mm and 2.80mm</b>	
<b>Welding parameter guidelines (with CO<sub>2</sub> shield)</b>	<b>Size</b>	<b>Range</b>
	1.6mm	150–300A, 25–28V
	2.0mm	200–350A, 26–28V
	2.40mm	250–450A, 27–29V
	2.80mm	300–450A, 27–30V
<b>Wire extension (stickout)</b>	<b>30–35mm</b>	