



Chandrabrabhu **E**nterprise **P**rivate **L**imited

HARDFACING WELDING WIRES

Name: CEPL-5002

Weld metal chemistry (with CO ₂ shield)	C = 0.40%, Mn = 14.0%, Si = 0.70%, Cr = 14.10%	
Hardness (3 layers)	22–24 HRC (Work hardens)	
Size	1.60mm, 2.00mm, 2.40mm and 2.80mm	
Welding parameter guidelines (with CO ₂ shield)	Size	Range
	1.6–2.0mm	200–350A, 26–28V
	2.4–2.8mm	250–400A, 27–29V
Wire extension (stickout)	35–40mm	

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