



Gas Shielded Hardfacing Flux Cored Wire

LQ439

CLASSIFICATION:

EN14700 DIN 8555
T Fe 7 MF 5-45-RPT

CHARACTERISTICS:

- Material: Stainless steel 0Cr13Ni4Mo.
- Shielding gas: CO₂(purity above 99.5%).
- Hardfacing deposit metal property: Excellent impact resistance& high-temperature oxidation resistance, suitable to metal-to-metal wear resistance, dust& slight abrasion resistance.
- Weldability: Stable welding arc, little spatter, excellent slag removal & perfect welding appearance.
- Suitable parent material: 45# steel (ASTM 1045, JIS S45C, DIN C45) or similar steel.
- Hardfacing thickness limit: No limit.
- Crack resistance: Perfect. Likewise depends on parent material, workpiece size, hardfacing thickness, welding process, etc.
- Machining: Turning, milling,
- Diameter&Package: φ1.6mm, 15Kg/Spool.

APPLICATION:

LQ439 is a stainless steel hard surfacing cored wire, suitable for hard surfacing continuous casting rolls and alloy steel axles piston etc.

All Weld Metal Chemical Composition (%) and Hardness

C	Mn	Si	Cr	Ni	Mo	Others	Hardness
0.1	<2.0	<1.5	13.5	4.0	1.2	<2.0	HRC40-50

Welding position: PA&PC.

PARAMETER:

Diameter(mm)	Amperage(A)	Voltage(V)	Stickout(mm)	Welding speed (mm/min)	Preheat(°C)
φ1.6	220~320	25~32	20~30	300~400	200~300

- ✧ φ1.6mm: deposit efficiency: 91%.
- ✧ φ1.6mm: deposit efficiency: 5kg/hour.

Notes:

1. Remove fatigue layer, slag, oil and rust before welding.
2. Welding crack may occur, not damage the wear resistance ability. Preheating and slow cooling can reduce the

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risk. Recommended preheating temperature $\geq 200^{\circ}\text{C}$.

3. Stored in cool and dry place, use up within three days once opened.

Remark: Chemical composition and hardness are tested according to prescribed standard, actual results might be vary depending on many factors, like weld procedure, temperature etc, please contact our sales before use it in the intended application