

COREWELD A250R

Flux cored wires [FCAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
DIN 8555 : MF-1-GF-250P		Hardfacing and repairing Automobile Agriculture

- A rutile, medium-alloy wire recommended for abrasion and impact resistant hardfacing, in the medium hardness range.
- Recommended as a buffer layer for difficult-to-weld steels.
- Ferritic-pearlitic structure.
- Good machinability.
- The weld deposit shows wear resistance and insensitivity to high dynamic loads, shocks and impacts.
- The temperature during hardfacing should not exceed 250°C.
- The overlay is well machinable, it can be flame and induction hardened.
- It does not require the use of buffer layers.

Application

Hardfacing of rollers of crawler tractors, guide rollers, rims of railway wheels, road wheels.


Base material

Steels			
Steel castings			

Typical chemical composition %

C	Si	Mn	Cr
0,08	0,46	1,20	1,40

Typical mechanical properties

Hardness	225-275 HB / The hardness of the build-up weld depends on the relevant welding conditions, the number of layers and the chemical composition of the base material. /
Hydrogen content	<5ml / 100g
Welding current	
Shielding gases acc. to EN ISO 14175	C1 - 100% CO2 / M21 - Ar + 15 - 25% CO2 /
Remarks	Heat thick elements to min. 150°C.

Welding parameters and packing

Ø	Welding current [A]	Voltage [V]	Gas flow	Weight of packet [kg]
1,2	130-250	23-28	12-18	15,0
1,6	220-420	26-32	12-18	15,0

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