COREWELD A350R

Flux cored wires [FCAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14700-A : T Fe1 DIN 8555 : MF 1-GF-350GP		Hardfacing and repairing

- Flux-cored wire for hardfacing elements exposed to very high impact and low and medium wear.
- The build-up weld can be machined by lathing and milling.
- Perfect for precise hardfacing of small elements.
- It can also be used in TIG technology.
- Unlimited number of layers.
- Ideal for regenerative surfacing as an intermediate layer before applying the final layer.
- Build-up weld free of cracks, resistant to abrasion.
- Particularly recommended for medium abrasion and friction conditions combined with impact resistance.
- Weld deposit with a chrome-manganese structure.

Typical chemical composition %

C	Si	Mn	Cr	Mo
0,15	0,45	1,20	1,70	0,20

Typical mechanical properties

Hardness	300-380 HB / 30-37 HRC / 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. /
Welding current	
Welding positions	
Shielding gases acc. to EN ISO 14175	C1 - 100% CO2 / M21 - Ar + 15 - 25% CO2 /
Remarks	To prevent embrittlement and cracking, all hardened layers must be removed from the base material. Preheating and post-weld heat treatment are not necessary for carbon-manganese steels. For high carbon steels, preheat 260°C. The build-up weld can be machined using high speeds and carbide tools.

Welding parameters and packing

ø	Welding current [A]	Voltage [V]	Gas flow	Weight of packet [kg]
1,2	130-280	23-31	20-25	15,0

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