

## COREWELD A450R

Flux cored wires [FCAW]

Hardfacing and repairing

<b>CLASSIFICATION:</b>  EN ISO 14700-A : T Fe1 DIN 8555 : MF 1-GF-45GP	<b>APPROVALS:</b>	<b>APPLICATION:</b>  Hardfacing and repairing Metallurgy (Steelworks) Mining Agriculture
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- Flux cored wire recommended for hardfacing elements exposed to very high impact and low abrasion.
- As a buffer layer under hard layers based on chromium and tungsten carbides.
- Perfect for precision surfacing of small elements.
- The weld deposit has a martensitic structure, resistant to very high impact and metal-to-metal wear.
- The build-up weld can be machined by lathing or milling.
- Can be used in TIG technology.
- Multiple layers can be applied.



### Application

Hardfacing of road wheels, shafts, clutch wheels, gears.

### Typical chemical composition %

<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>Cr</b>	<b>Mo</b>
0,25	0,60	1,6	2,8	0,50

### Typical mechanical properties

<b>Hardness</b>	380 - 450 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 /
<b>Wire/rod type</b>	flux cored
<b>Welding current</b>	
<b>Welding positions</b>	
<b>Shielding gases acc. to EN ISO 14175</b>	C1 - 100% CO <sub>2</sub> / M21 - Ar + 15 - 25% CO <sub>2</sub> /

### Welding parameters and packing

∅	Welding current [A]	Voltage [V]	Gas flow	Weight of packet [kg]
1,2	180-360	22-34	20-25	15,0
1,6	180-450	22-40	20-25	15,0

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