

COREWELD A 210MnNi

Flux cored wires [FCAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
DIN 8555 : MF 7-GF-200-KNP		Hardfacing and repairing

- Flux cored wire for welding parts of manganese steel, which are exposed to high impact and cracking.
- The deposit is austenitic and nonmagnetic, though, crack free and work hardening.

Application

Crushers, railway crossing, dredger buckets, crusher jaws, parts of manganese steel, etc.

Typical chemical composition %

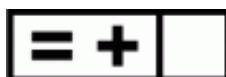
C	Si	Mn	Ni
0,30	0,40	13,0	3,0

Typical mechanical properties

Hardness app. 200 HB / app. 420 HB (after strain hardening) /

Wire/rod type gas or selfshielding

Welding current



Welding parameters and packing

∅	Welding current [A]	Voltage [V]	Weight of packet [kg]
1,6	160-260	20-26	15,0/30,0
2,0	240-280	22-27	15,0/30,0
2,4	280-340	24-28	15,0/30,0
2,8	320-400	25-29	15,0/30,0

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