

## COREWELD A350

Flux cored wires [FCAW]

Hardfacing and repairing

<b>CLASSIFICATION:</b> EN ISO 14700-A : T Fe 1 DIN 8555 : MSG 1 GF 350P	<b>APPROVALS:</b>	<b>APPLICATION:</b> Hardfacing and repairing
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- Metallic flux cored wire recommended for making welds resistant to impact in the low hardness range.
- Very good weldability, both spray and short-arc welding possible.
- No spatter in the spray.
- Weld deposit without slag, smooth, easily machinable.
- The interpass temperature should not exceed 200°C.
- It can be used for hardfacing in TIG technology.

### Application

Hardfacing, regeneration, preventive welds, plated layers: metal containers and tanks, machines and devices, steel tools, all kinds of crane wheels, trolley wheels, undercoating layers of cylinders, track rollers, crane rails, shafts.


### Base material

Steels	
Cast steels	

### Typical chemical composition %

<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>Cr</b>
0,15	0,50	2,0	2,5

### Typical mechanical properties

<b>Hardness</b>	app. 310 - 380HB / The hardness of the build-up weld depends on the relevant welding conditions, the number of layers and the chemical composition of the parent material. /
<b>Wire/rod type</b>	gas or selfshielding
<b>Welding current</b>	
<b>Shielding gases acc. to EN ISO 14175</b>	M13 - Ar + 0.5 - 3% O2 / M21 - Ar + 15 - 25% CO2 /

### Welding parameters and packing

∅	Welding current [A]	Voltage [V]	Gas flow	Weight of packet [kg]
1,2	120-220	19-22	2,5 - 8,0	15,0
1,6	160-260	20-26		15,0
2,0	220-280	22-27		15,0
2,4	260-340	24-28		15,0
2,8	320-460	26-30		15,0

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