

COREWELD A400

Flux cored wires [FCAW]

Hardfacing and repairing

CLASSIFICATION: EN ISO 14700-A : T Fe 1 DIN 8555 : MF 1-GF-400-P	APPROVALS:	APPLICATION: 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, welding also possible in short arc.
- Weld deposit without slag, smooth, easily machinable.
- It can be used for hardfacing in TIG technology.

Application

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



Base material

Steels	
Cast steels	

Typical chemical composition %

C	Si	Mn	Cr
0,20	0,50	2,20	2,10

Typical mechanical properties

Hardness	375-450 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 /
Wire/rod type	gas or selfshielding
Welding current	
Welding positions	
Shielding gases acc. to EN ISO 14175	C1 - 100% CO2 / M21 - Ar + 15 - 25% CO2 /
Remarks	The interpass temperature should not exceed 200°C.

Welding parameters and packing

∅	Welding current [A]	Voltage [V]	Gas flow	Weight of packet [kg]
1,2	210-290	26-33	13-17	15,0

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