

COREWELD A480

Flux cored wires [FCAW]

Hardfacing and repairing

CLASSIFICATION: DIN 8555 : MF 5-GF-450-PRT	APPROVALS:	APPLICATION: Hardfacing and repairing
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- Flux cored wire for submerged arc welding.
- Overlay resistant to impact, medium abrasion and corrosion.
- The overlay is durable under continuous exposure to high temperature.
- The interpass temperature should be a maximum of 450°C.

Application

Feed rolls of the heavy rolling mill and lead rolls

Typical chemical composition %

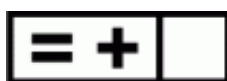
C	Cr	Ni	Inne
0,25	12,0	2,3	2,5

Typical mechanical properties

Hardness 480-500 HB (480°C) / 460-490 HB (510°C) / 440-480 HB (540°C) / 400-430 HB (570°C) / 320-350 HB (600°C) /

Wire/rod type gas or selfshielding

Welding current



Welding parameters and packing

∅	Welding current [A]	Voltage [V]	Weight of packet [kg]
1,2	120-220	19-22	15,0/30,0
1,6	160-260	20-26	15,0/30,0
2,0	220-280	22-27	15,0/30,0
2,4	260-340	24-28	15,0/30,0
2,8	300-400	25-29	15,0/30,0
3,2	320-460	26-30	15,0/30,0

METALWELD-FIPROM POLSKA spółka z o.o.

ul. Mikołajczyka 57, 41-200 Sosnowiec

+48 (32) 297 75 50 - 51

+48 (32) 297 75 88

export@metalweld.pl