

## COREWELD A55

Flux cored wires [FCAW]

Hardfacing and repairing

<b>CLASSIFICATION:</b> EN ISO 14700-A : T Fe14 DIN 8555 : MF 10-60-GR	<b>APPROVALS:</b>	<b>APPLICATION:</b> Hardfacing and repairing
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- Flux cored welding wire.
- Build-up weld is highly resistant to abrasion with a small impact, cannot be heat treated or machined.
- Structurally: chromium primary carbides and carbide eutectic in an austenitic matrix.
- The best results are obtained with the second layer.
- Processing by grinding only.

### Application

Screw conveyors in various applications (brick production), dredge pump impellers, cutters for dredges.

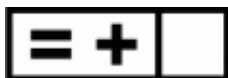
### Base material

Steels  
Cast steels

### Typical chemical composition %

<b>C</b>	<b>Si</b>	<b>Cr</b>	<b>B</b>
4,8	1,0	28,0	+

### Typical mechanical properties

<b>Tensile strength Rm [N/mm<sup>2</sup>]</b>	1800-2000
<b>Hardness</b>	55-59 HRC / 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>	gas or selfshielding
<b>Welding current</b>	

### 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

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