

COREWELD A55

Flux cored wires [FCAW]

Hardfacing and repairing

CLASSIFICATION: EN ISO 14700-A : T Fe14 DIN 8555 : MF 10-60-GR	APPROVALS:	APPLICATION: 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.

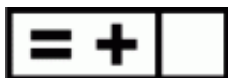
Base material

Steels
Cast steels

Typical chemical composition %

C	Si	Cr	B
4,8	1,0	28,0	+

Typical mechanical properties

Tensile strength Rm [N/mm²]	1800-2000
Hardness	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. /
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

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