

COREWELD A62

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 wire for hardfacing, creating a stainless deposit based on chromium carbides.
- Excellent resistance to abrasion and low impact.
- Can be used whenever high abrasion is expected.
- The best results are obtained with the second layer.
- The recommended maximum build-up weld thickness is 10 mm.
- It cannot be subjected to heat treatment, machining or forging - it can only be processed by grinding.

Application

Ideal for highly abrasive components, e.g. conveyor belts, stirrers, components used in the production and processing of cement and concrete, bucket and bucket teeth.


Base material

Steels
Cast steels

Typical chemical composition %

C	Si	Mn	Cr	B
5,5	1,2	1,2	26,0	+

Typical mechanical properties

Hardness	ok. 62 HRC (after welding) / 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	
Shielding gases acc. to EN ISO 14175	M13 - Ar + 0.5 - 3% O2 /

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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