

COREWELD A64

Flux cored wires [FCAW]

Hardfacing and repairing

CLASSIFICATION: EN ISO 14700-A : T Fe15 DIN 8555 : MF 10-GF-65-GZ	APPROVALS:	APPLICATION: Hardfacing and repairing
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- High-alloy flux cored wire containing C, Cr, Nb and B based carbides, which makes the build-up weld resistant to high abrasion.
- When hardfacing old surfaces, it is recommended to use a 307 or 17Mn13Cr primer.
- The weld metal contains chromium carbides in an austenitic matrix with the addition of niobium carbides.
- Relaxation cracks may appear, which do not affect the properties of the build-up weld.
- Operation at 450°C.

Application

Mineral, steel, cement and coal industries. For hardfacing fan blades, excavator buckets, screws, pumps, dredgers, etc.


Base material

Steels
Cast steels

Typical chemical composition %

C	Si	Cr	Nb	B
5,4	1,1	22,0	7,0	+

Typical mechanical properties

Hardness	app. 63 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]
1,6	160-260	19-22	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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