

COREWELD A66

Flux cored wires [FCAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION: Hardfacing and repairing
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- Hardfacing flux cored wire with extremely hard C, Cr, Mo, Nb, V and W based carbides.
- Recommended for hardfacing when extremely strong mineral wear resistance is required.
- The deposit is wear resistant up to 650°C.
- At 400°C the hardness decreases about 4%, in 650°C about 10%.
- Before hardfacing on old surfaces we recommend to make buffer layer of Coreweld A 200 or Coreweld A 250.

Application

Blast furnace cones, crushers, etc.

Typical chemical composition %

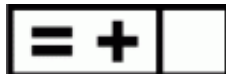
C	Si	Mn	Cr	Mo	V	Nb	W
5,2	1,0	0,20	21,0	7,0	1,0	7,0	2,0

Typical mechanical properties

Hardness app. 63 HRC (20°C) / app. 61 HRC (400°C) / app. 57 HRC (650°C) /

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	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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