

COREWELD NICOMO

Flux cored wires [FCAW]

Hardfacing and repairing

CLASSIFICATION:

DIN 8555 : MF 4-UM- 350-CKPSTZ

W.Nr. : 1.6356

APPROVALS:

Hardfacing and repairing

- Flux cored wire for repairing of dies and punching dies, especially those exposed to a huge impact.
- Particularly recommended for H13 type martensitic steels and martensitic "aging" steels.
- The deposit is very easily machined mechanically.
- The deposit can be heat treated if higher hardness is required.
- The weld deposit significantly increases the hardness of the welded edge of cold cutting tools and blades.
- Operating temperature 20 to 450°C.

Application

Facing dies, stamping tools, metal drawing tools, pressure die casting tools

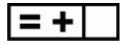
Typical chemical composition %

C	Si	Ni	Мо	Co	Ti
0,03	0,30	18,0	4,0	12,0	+

Typical mechanical properties

Hardness	ok. 350 HB (after welding) / ok. 55 HRC (soft annealed 4h at 480°C) /		
Wire/rod type	gas shielded arc welding		

Welding current



Welding parameters and packing

Ø	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

METALWELD-FIPROM POLSKA spółka z o.o.

ul. Mikołajczyka 57, 41-200 Sosnowiec

+48 (32) 297 75 50 - 51

+48 (32) 297 75 88

export@metalweld.pl