

## COREWELD NiCoMo

Flux cored wires [FCAW]

Hardfacing and repairing

<b>CLASSIFICATION:</b>		<b>APPROVALS:</b>		<b>APPLICATION:</b>	
DIN 8555 : MF 4-UM- 350-CKPSTZ W.Nr. : 1.6356				Hardfacing and repairing	
<ul style="list-style-type: none"><li>Flux cored wire for repairing of dies and punching dies, especially those exposed to a huge impact.</li><li>Particularly recommended for H13 type martensitic steels and martensitic "aging" steels.</li><li>The deposit is very easily machined mechanically.</li><li>The deposit can be heat treated if higher hardness is required.</li><li>The weld deposit significantly increases the hardness of the welded edge of cold cutting tools and blades.</li><li>Operating temperature 20 to 450°C.</li></ul>					
Application					
Facing dies, stamping tools, metal drawing tools, pressure die casting tools					
Typical chemical composition %					
C	Si	Ni	Mo	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		<div><div>= +</div><div></div></div>			
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		
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