

COREWELD A650R

Flux cored wires [FCAW]

Hardfacing and repairing

CLASSIFICATION: EN ISO 14700-A : T Fe8 DIN 8555 : MF 6-GF-60GP	APPROVALS:	APPLICATION: Hardfacing and repairing Mining
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- Flux cored wire recommended for hardfacing of elements exposed to high impact and medium and high abrasion, as well as metal-to-metal wear.
- The build-up weld is hard, smooth, without microcracks, resistant to distortion and impact. It can only be machined by grinding.
- The weld deposit after hardfacing in the first layer reaches a hardness of approx. 60 HRC.
- It can be used in TIG technology.
- Possibility of hardfacing thinner elements with complex shapes.
- Martensitic structure.

Application

Regeneration of elements in the mining industry, construction, metallurgy, agriculture

Base material

Steels
Cast steels

Typical chemical composition %

C	Si	Mn	Cr	Mo	W
0,50	2,50	0,50	6,80	0,70	0,55

Typical mechanical properties

Hardness	57-62 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. /
Welding current	
Welding positions	
Shielding gases acc. to EN ISO 14175	C1 - 100% CO ₂ / M21 - Ar + 15 - 25% CO ₂ /

Welding parameters and packing

∅	Welding current [A]	Voltage [V]	Gas flow	Weight of packet [kg]
1,2	180-360	22-34	20-25	15,0
1,6	180-450	22-40	20-25	15,0

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