

COREWELD HT58

Flux cored wires [FCAW]

Hardfacing and repairing

CLASSIFICATION: DIN 8555 : MF 6-GF-55-PT	APPROVALS:	APPLICATION: Hardfacing and repairing
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- Flux cored wire forming a deposit that is heat and thermal shock resistant, working in temp. up to 600°C.
- The interpass temperature should be max. 250°C.
- For the maintenance of hot working tools, significantly extends their service life.

Application

Screw presses, blanking dies, punches, forging dies, etc.


Base material

Steel			
Cast steels			

Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo	V	W	Ti
0,32	0,70	0,60	5,70	0,50	3,00	0,70	3,00	0,30

Typical mechanical properties

Tensile strength Rm [N/mm2]	1800-2000
Hardness	52-54 HRC (after welding) / 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	flux-cored
Welding current	
Shielding gases acc. to EN ISO 14175	I1 - Ar / M13 - Ar + 0.5 - 3% O2 /

Welding parameters and packing

∅	Weight of packet [kg]
1,2	15,0 / 30,0
1,6	15,0 / 30,0
2,0	15,0 / 30,0
2,4	15,0 / 30,0
2,8	15,0 / 30,0
3,2	15,0 / 30,0

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