

COREWELD A660

Flux cored wires [FCAW]

Hardfacing and repairing

CLASSIFICATION: EN ISO 14700-A : Z T Fe 8-60GP	APPROVALS:	APPLICATION: Hardfacing and repairing
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- Metal flux cored wire for hardfacing.
- The microstructure of the deposit is martensitic matrix of a tools steel with the niobium carbides.
- The deposit is resistant against cracking and abrasion combined with wear due to the stress.
- The base material should be preheated to 250 - 300°C.

Application

Crusher rolls, hammers, pulveriser rolls, etc.

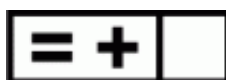
Typical chemical composition %

C	Si	Mn	Cr	Mo	V	Nb	W
1,4	0,80	1,0	7,0	0,80	1,0	8,0	1,2

Typical mechanical properties

Hardness 55-57 HRC /

Welding current



Welding parameters and packing

∅	Welding current [A]	Voltage [V]
1,2	120-220	20-23
1,6	160-260	20-26
2,0	220-280	24-27
2,4	260-340	25-27
2,8	300-400	25-29

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