

OA MnCr

CATEGORY	FCAW Flux-Cored
TYPE	Tubular wire weldable without protective gas for rebuilding and buffer layers before hardfacing with extreme resistance to heavy impact loads.
APPLICATIONS	Rebuilding heavy steel parts, buffer layers, rails, rails crossings, dredger teeth, blast furnace mantles etc..
PROPERTIES	Austenitic deposit with strain hardening properties and no limits in the number of layers. The deposit is non magnetic and can not be flame cut.

CLASSIFICATION	AWS	A 5.21:
	EN ISO	14700: T Fe9
	DIN	8555: MF 7-250-KNP

SUITABLE FOR	Rebuilding, buffer layers, rails, rails crossings, dredger teeth, blast furnace mantles
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APPROVALS	CE approved
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WELDING POSITIONS:	
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WELD METAL ANALYSIS %			
C	Mn	Cr	
0.3-0.5	13.0-15.0	13.0-15.0	

MECHANICAL PROPERTIES							
Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
AW							210-240
SH							450-570

AW: as welded SH: after strain hardening

WELDING PARAMETERS / PACKING				
Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool / drum
1.6	24-35	150-350	S-300 / Drum	15 / 250
2.0	26-35	200-400	S-300 / Drum	15 / 250
2.4	26-35	250-450	S-300 / Drum	15 / 250
2.8	28-35	250-450	S-300 / Drum	15 / 250

REDRYING TEMPERATURE	150°C / 24hr.
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