

AA M57-62

CATEGORY FCAW Flux-Cored

TYPE Seamless medium alloyed metal powder fluxcored wire without slag for hardfacing using Ar-Co² mix

APPLICATIONS Rebuilding and cladding parts against strong abrasion and heavy impact.

PROPERTIES Due to the high resistance to cracking and toughness, all weld metal requires no buffer layer except on materials considered critical. In this situation Ceweld ER 100 S-G is recommended. Suited for wear parts subject to heavy impact and shock. The interpass temperature should be maximum 250°C. The weld metal is machinable by special carbide tools, hardening is possible. The maximum hardness is dependent on the base metal and is achieved in the first layer.

CLASSIFICATION

AWS	A 5.21:
EN ISO	14700: T Fe4
DIN	8555: MSG 6 - GF - 60 P

SUITABLE FOR 55-62 HRc hardfacing alloy against heavy impact and shock, bucket, loaders, crusher jaws, crusher cones, pumps, sand, snow scratchers, stone cutting tools etc.

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cr	Mo
0.50	1.50	0.60	6.00	0.90

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc
				-20°C	-40°C	-60°C	
AW							57-62

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) (DC+)	spool type	kg / spool	kg / pallet
1.2	14-32	80-300	D-200	5	1000
1.2	14-32	80-300	K 300	15	1024
1.6	15.8-34	100-420	K 300	15	1024

REDRYING TEMPERATURE not required

GAS ACC. EN ISO:14175 M21