

CATEGORY FCAW Flux-Cored

TYPE Open Arc wire for buffer layers and rebuilding against high impact and pressure weldable without protective gas.

APPLICATIONS 385-415 HB, rebuilding and hardfacing alloy for extreme critical applications where extreme impact loads and surface pressure causes deformation and cracks that need to be solved.

PROPERTIES Due to the high resistance to cracking and toughness, all weld metal requires no buffer layer. Suited for wear parts subject to heavy pressure, impact and shock. The interpass temperature should be maximum 250°C. The weld metal is machinable with carbide tip tools, hardening is possible. The maximum hardness is dependent on the base metal and is usually already achieved in the first layer.

CLASSIFICATION EN ISO 14700: T ZFe1
DIN 8555: MF 3-400-ST

SUITABLE FOR Rebuilding wornout wheels, hammers, lime stone crushing rollers, crossings, concrete bars, crane, railway and tram tracks, conveyors and transport surfaces, kiln tire support rollers, bucket and loader teeth, crusher jaws, buffer layers prior to hard facing.

APPROVALS No Approvals Found

WELDING POSITIONS: 

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Mo	V
0.15	0.4	1.5	2	3.2	0.4

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} MPa	R _m MPa	A ₅ (%)	Hardness Brinell Hardness
As Welded /				Avg. 410

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A) (DC+)	SPOOL TYPE	KG / SPOOL / DRUM	KG / PALLET
1.2	21-33	100-280	S-300	15 / 300	1080 / 600
1.6	24-33	160-310	S-300	15 / 300	1080 / 600
2.4	26-35	200-350	K-415	25 / 300	1050 / 600
2.8	27-36	225-370	K-415	25 / 300	1050 / 600

REDRYING TEMPERATURE 140°C / 24 hr

GAS ACCORDING EN 14175