

CATEGORY	GMAW(-C) Metalcored Wires	
TYPE	Seamless medium alloyed metal powder fluxcored wire without slag for hardfacing using Ar-CO2 Mixgas	
APPLICATIONS	375-450 HB, hardfacing and rebuilding alloy for wornout wheels, rails, tires, conveyors, crossings, shafts, bufferlayers prior to hardfacing. excelent wear and abrasion resistance against heavy impact and shock, machinable with carbide tools.	
PROPERTIES	Due to the high resistance to cracking and excelent toughness, all weld metal requires no buffer layer except on materials considered critical. Suited for wear parts subject to heavy 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 achieved already in the first layer.	
CLASSIFICATION	EN ISO DIN	14700: T ZFe2 8555: MF 1-GF-40 GPS
SUITABLE FOR	Conveyors and transport surfaces, tires, bucket and loader teeth, cruscher jaws, Bufferlayers, crane wheels, axis, gear parts, winches etc.	
APPROVALS	No Approvals Found	

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Mo
0.4	0.7	1.5	2.5	0.5

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Hardness Rockwell C
As Welded /				Avg. 40

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A)	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	1080
1.6	18-34	100-420	K 300	15	1080

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	M21