

CATEGORY	FCAW Flux-Cored		
TYPE	High-alloyed tubular wire on a C-Cr. carbide basis for abrasive wear resistance in combination with corrosion.		
APPLICATIONS	Rebuilding and or protecting wear parts against extreme abrasion in combination with corrosion, with low impact.		
PROPERTIES	Can be welded crack free by preheating approximately 450°C and keep that also as interpass temperature. Slowly cooling down, for example in an oven.		
CLASSIFICATION	EN ISO DIN	14700: T ZFe14 8555: MF 10-55-CGT	
SUITABLE FOR	56-59 HRc hardfacing alloy, Mixing peddles, Press screws, Kneading machine, screw conveyors, pumps etc.		
APPROVALS	No Approvals Found		

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr
3.7	1.2	0.2	32

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Hardness Rockwell C
As Welded /				Avg. 57

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A)	SPOOL TYPE	KG / SPOOL
1.6	20-27	120-260	S-300 / COIL B-450 / DRUM	15 / 30 / 300
2.0	22-27	140-320	S-300 / COIL B-450 / DRUM	15 / 30 / 300
2.4	22-29	160-380	S-300 / COIL B-450 / DRUM	15 / 30 / 300
2.8	22-30	180-400	S-300 / COIL B-450 / DRUM	15 / 30 / 300

REDRYING TEMPERATURE	140°C / 24 hr
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GAS ACCORDING EN 14175