

CATEGORY SAW Arc Submerged

TYPE Fluxcored SAW wire for cladding and rebuilding wornout parts.

APPLICATIONS 325-375 HB, Hardfacing and rebuilding alloy for wornout wheels, rails, tracks, tires, conveyors, crossings, buffer layers prior to Hardfacing. Excellent wear and abrasion resistance against heavy impact and shock, good machinable with carbide tools

PROPERTIES To be used with neutral flux and basicity above 1.5. Suitable fluxes are FL 851 and FL 155

CLASSIFICATION EN ISO 14700: T Fe2

SUITABLE FOR Rails repair, crossings, concrete bars, crane, railway and tram tracks, conveyors and transport surfaces, tires, bucket and loader teeth, crusher jaws, buffer layers etc.

APPROVALS No Approvals Found

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	
0.12	0.8	1.8	1	

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0.2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Hardness Brinell Hardness
As Welded /				Avg. 350

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
2,4	28-30	250-350	K-300	15 / 300	1080 / 600
3.2	29-32	300-450	K-415	25 / 300	1050 / 600
4.0	30-34	350-600	K-415	25 / 300	1050 / 600

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175