

DESCRIPTION

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Self shielded flux cored wire depositing an austenitic alloy designed for rebuilding of 14% Manganese steel parts.

SUITABLE FOR

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Overlaying of rails

TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

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C	Mn	Si	Cr	Mo	V	Fe
0.35	12.0	0.2	3.50	2.5	1	Bal.

TYPICAL MECHANICAL PROPERTIES

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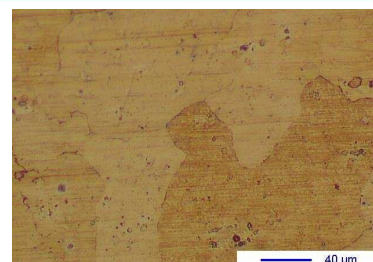
Hardness as welded

230 HB

GENERAL CHARACTERISTICS

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- Microstructure: Austenite
- Machinability: Good with carbide tipped tools
- Oxy-acetylene cutting: Cannot be flame cut
- Deposit thickness: As required
- Flux cored



WELDING PARAMETERS & ECONOMICAL DATA

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Diameter [mm]	Current [A]	Voltage [V]	Stick-Out	Article code	Packaging	Availability
1,6	180-200	26-30	35-40	63938	Spool 15 Kg	On request with minimal quantity

The information about the products contained in the data sheets are based on intensive tests and careful investigations. However we can't assume any form of liability concerning the exactness of it. The information may be changed or updated without previous notice. The user is invited to test the product with regard to his own application and responsibility.