

DESCRIPTION

1

Open-arc hardsurfacing flux-cored wire

SUITABLE FOR

2

Undercarriage rollers and Idlers, shovel teeth, shear blades.

TYPICAL CHEMICAL ANALYSIS (WEIGHT %)

3

| | C | Mn | Si | Cr | Mo | V | Fe |
|----------|------|-----|-----|------|-----|---|------|
| All Weld | 0.25 | 0.3 | 0.8 | 4.80 | 3.2 | 1 | Bal. |

TYPICAL MECHANICAL PROPERTIES

4

Hardness as welded

51 HRC

GENERAL CHARACTERISTICS

5

- | | |
|-------------------------|---|
| ▪ Microstructure | Martensite |
| ▪ Machinability | Grinding only |
| ▪ Oxy-acetylene cutting | Flame cut is difficult |
| ▪ Deposit thickness | Depends upon application and procedure used |
| ▪ Metal cored | |

WELDING PARAMETERS & ECONOMICAL DATA

6

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.