

COREWELD A64M

Flux cored wires [FCAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
DIN 8555 : MF10-GF-60-G		Hardfacing and repairing

- High C, Cr and Nb alloyed flux cored wire for high abrasive wear.
- The weld deposit consists of chrome and niobium carbides.
- Weld metal can not be machinable.
- Maximum number of layers is three.

Application

Steel, coal, cement and mineral industry

Typical chemical composition %

C	Si	Cr	Nb
5,4	1,1	22,0	7,0

Typical mechanical properties

Hardness	app. 62 HRC /
Wire/rod type	gas or selfshielding
Welding current	

Welding parameters and packing

Ø	Welding current [A]	Voltage [V]	Weight of carton [kg]
1,6	160-260	20-26	15,0/30,0
2,0	220-280	22-27	15,0/30,0
2,4	260-340	24-28	15,0/30,0
2,8	300-400	25-29	15,0/30,0
3,2	320-460	26-30	15,0/30,0

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