

## COREWELD A600R

Flux cored wires [FCAW]

Hardfacing and repairing

<b>CLASSIFICATION:</b>	<b>APPROVALS:</b>	<b>APPLICATION:</b>
EN ISO 14700-A : T Fe8 DIN 8555 : MF 6-GF-60 P		Hardfacing and repairing Metallurgy (Steelworks) Mining Agriculture

- Flux cored wire recommended for hardfacing of elements exposed to very high impact and medium abrasion.
- The build-up weld is hard, without micro-cracks, resistant to distortion and impact, as well as to metal-to-metal wear. It can only be machined by grinding.
- Perfect for precision hardfacing of small elements.
- Can be used in TIG technology.



### Application

Teeth of excavator buckets and grapples, components of crushing hammers and jaws, components of pumps, blades and mixer blades. Regeneration of elements in the mining industry, construction, metallurgy, agriculture.

### Typical chemical composition %

<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>Cr</b>	<b>Mo</b>
0,50	2,80	0,50	7,50	0,50

### Typical mechanical properties

<b>Hardness</b>	55 - 60 HRC / The hardness of the build-up weld depends on the relevant welding conditions, the number of layers and the chemical composition of the base material /
<b>Welding current</b>	
<b>Welding positions</b>	
<b>Shielding gases acc. to EN ISO 14175</b>	C1 - 100% CO <sub>2</sub> / M21 - Ar + 15 - 25% CO <sub>2</sub> /
<b>Remarks</b>	When hardfacing the base material of easily hardened steels, steels with high carbon content, steels with limited weldability, a buffer layer should be used, e.g. of material type 307.

### Welding parameters and packing

Ø	Welding current [A]	Voltage [V]	Gas flow	Weight of packet [kg]	Weight of carton [kg]
1,2	180 - 360	22 - 34	20 - 25	15	15
1,6	180 - 450	22 - 40	20 - 25	15	15

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