COREWELD A430Mo

Flux cored wires [FCAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
DIN 8555 : MF 6-GF-50-CPR		Hardfacing and repairing

- Flux cored wire for plating and joining ferritic chrome steels and cast steel.
- Appropriate heat treatment is recommended when welding.
- The overlay is crack resistant up to 800°C and can be tempered.
- The wire can work at room temperature up to 500°C.
- Resistant to oxidation and tempering.
- Resistant to flaking up to 950°C.
- Can be hardened.

Base material

EN	W. Nr
X35CrMo17	1.4122

Typical chemical composition %

C	Cr	Mo
0,35	17,0	1,0

Typical mechanical properties

Yield strength Re [N/mm2]	600
Tensile strength Rm [N/mm2]	800
Elongation A5 [%]	12
Hardness	after heat treatment (hardening): approx. 48 HRC /
Welding current	
Shielding gases acc. to EN ISO 14175	C1 - 100% CO2 / M13 - Ar + 0.5 - 3% O2 /
Remarks	Usage Recommendations: Ferritic steels tend to be brittle due to grain growth. The heat input should be as small as possible. Low-alloy materials should be heated from 150°C to 350°C, depending on thickness. Heat treatment after welding (hardfacing) is not necessary.

Welding parameters and packing

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

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