

COREWELD A610

Flux cored wires [FCAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
DIN 8555 : MF 6-GF-60-PT		Hardfacing and repairing

- Flux cored wire for hardfacing based on Cr, Mo, W and V.
- It has excellent resistance to impact, erosion and medium abrasion.
- The overlay does not lose its hardness up to 550°C.
- The overlay can be heat treated to increase its hardness.
- The overlay is very resistant to cracking.
- Coreweld A610 can be used both with and without a backing, any number of layers can be overlaid.


Application

Forming rollers in metallurgy, bucket teeth, screw conveyors, hammers, etc.

Typical chemical composition %

C	Si	Mn	Cr	Mo	V	W
0,50	1,0	3,0	6,0	1,6	1,5	1,0

Typical mechanical properties

Hardness	55-58 HRC /
Wire/rod type	gas or selfshielding
Welding current	

Welding parameters and packing

Ø	Welding current [A]	Voltage [V]	Weight of packet [kg]
1,2	120-220	19-22	15,0/30,0
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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