

COREWELD A620Nb

Flux cored wires [FCAW]

Hardfacing and repairing

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

- Flux cored wire for surfacing, giving a deposit based on chromium, molybdenum, nickel and vanadium carbides.
- Excellent resistance to abrasion, impact and corrosion, also at high temperatures.

Application

Crusher rolls

Typical chemical composition %

C	Cr	Ni	Mo	Nb
0,65	5,0	0,60	1,0	3,3

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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