

## COREWELD A63

Flux cored wires [FCAW]

Hardfacing and repairing

<b>CLASSIFICATION:</b>	<b>APPROVALS:</b>	<b>APPLICATION:</b>
EN ISO 14700-A : T Fe15 DIN 8555 : MF 10-GF-65-GZ		Hardfacing and repairing

- Flux cored welding wire.
- Build-up weld resistant to high abrasion and high temperatures. Its thickness should not exceed 8 mm.
- The best results are obtained with the second layer.
- The weld cannot be subjected to heat treatment, machining or forging.

### Application

Typical applications include surface hardening of cones and crushers, hammers, earthmoving buckets, loosening points.


### Base material

Steels  
Cast steels

### Typical chemical composition %

<b>C</b>	<b>Cr</b>	<b>V</b>	<b>W</b>	<b>B</b>
3,8	22,0	0,80	0,80	1,0

### Typical mechanical properties

<b>Hardness</b>	app. 63 HRC / app. 53 HRC (400°C) / app. 47 HRC (600°C) / 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>Wire/rod type</b>	gas or selfshielding
<b>Welding current</b>	

### 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

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