

COREWELD A63

Flux cored wires [FCAW]

Hardfacing and repairing

CLASSIFICATION:

EN ISO 14700-A: T Fe15

DIN 8555: MF 10-GF-65-GZ

APPROVALS:

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 %

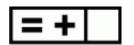
С	Cr	V	W	В
3,8	22,0	0,80	0,80	1,0

Typical mechanical properties

Hardness	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. /

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

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