

COREWELD A680Ti

Flux cored wires [FCAW]

Hardfacing and repairing

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

- Flux cored welding wire.
- Ductile and impact resistant overlay.
- It guarantees high resistance to abrasion and wear caused by impact stress.
- The deposit has a martensitic structure with titanium carbides.
- Used in the cement industry and recycling.

Application

Crusher rollers, crusher hammers, bandages in cement mills.

Typical chemical composition %

C	Mn	Cr	Mo	Ti
1,8	1,4	7,0	1,4	5,0

Typical mechanical properties

Hardness	55-56 HRC /
Wire/rod type	gas or selfshielding
Welding current	

Welding parameters and packing

Ø	Welding current [A]	Voltage [V]	Weight of packet [kg]
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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