

COREWELD A71 ULTRA

Flux cored wires [FCAW]

Hardfacing and repairing

CLASSIFICATION:			APPROVALS:				APPLICATION:		
DIN 8555 : MF 6-GF-70-GT							Hardfacing and repairing		
 Metal cored hardfacing wire. The deposit contains a high volume of extremely hard borium carbides. Recommended when high abrasive and erosion resistance at temperatures up to 750°C. We suggest to remove the old deposit before surfacing and use buffer layer with COREWELD A 250 MnCr. 									
Application									
Exhaust fans, furnace chutes, paddles, mixer blades, transport and press screws, conveyors in the mining, cement, steel industries, waste recycling, petrochemical and energy industries.									
Typical chemical composition %									
	Si 0,70	•••••••••••••••••••••••••••••••••••••••	10 3,0	Nb 5,8	Fe rest	W 5,6	B 4,0		
Typical mechanical properties									
Hardness	66-68 H	66-68 HRC (first layer) / 67-71 HRC (second layer) /							
Wire/rod typ	gas shi	gas shielded arc welding							
Welding cur	=	= +							
Welding parameters and packing									
ø Welding 1,6 160-300			-	nt [A]	Voltage [V] 23-32			Weight of packet [kg] 15,0/30,0	
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