

COREWELD HT38

Flux cored wires [FCAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
DIN 8555 : MF 1-GF-40-PT		Hardfacing and repairing Agriculture

- Flux cored wire for hardfacing elements exposed to high impact and thermal shock.
- Unlimited number of layers.
- The build-up weld is crack-free and can be machined. It retains its hardness up to 550°C.
- Pre-heat treatment should be adapted to the base material.
- For material with a content of approx. 0.6% C, the temperature should be min. 350°C.

Application

Hardfacing of hot working tool steels, such as forging dies, presses, etc.


Base material

Steel			
Cast steels			

Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo	V	W
0,10	0,40	0,90	5,00	0,70	3,50	0,20	0,15

Typical mechanical properties

Hardness	36-42 HRC (after welding) / 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. /
Welding current	
Shielding gases acc. to EN ISO 14175	M13 - Ar + 0.5 - 3% O2 / M21 - Ar + 15 - 25% CO2 /

Welding parameters and packing

Ø	Gas flow	Weight of packet [kg]
1,2	12,0-18,0	15,0
1,6	12,0-18,0	15,0

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