

COREWELD HT52

Flux cored wires [FCAW]

Hardfacing and repairing

CLASSIFICATION: DIN 8555 : MF 1-GF-55-PT	APPROVALS:	APPLICATION: Hardfacing and repairing
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- Flux cored wire for hardfacing elements exposed to very high impact and thermal shock, working in temp. up to 600°C.
- The interpass temperature should be max. 250°C.
- Unlimited number of layers.
- 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 screw presses, forging dies, presses, blanking dies, etc.


Base material

Steel			
Cast steels			

Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo	V	W	Ti
0,25	0,70	0,60	10,00	1,00	3,00	0,30	1,40	0,20

Typical mechanical properties

Tensile strength Rm [N/mm²]	1800-2000
Hardness	52-55 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. /
Wire/rod type	flux-cored
Welding current	
Shielding gases acc. to EN ISO 14175	M13 - Ar + 0.5 - 3% O ₂ / M21 - Ar + 15 - 25% CO ₂ /

Welding parameters and packing

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

METALWELD-FIPROM POLSKA spółka z o.o.

ul. Mikołajczyka 57, 41-200 Sosnowiec

+48 (32) 297 75 50 - 51

+48 (32) 297 75 88

export@metalweld.pl