

COREWELD A600

Flux cored wires [FCAW]

Hardfacing and repairing

CLASSIFICATION:		APPROVALS:		APPLICATION:	
EN ISO 14700-A : T Fe2 DIN 8555 : MF 6-GF-60GP				Hardfacing and repairing	
- Flux cored wire recommended for hardfacing of elements exposed to very high impact and medium abrasion. - The build-up weld is hard, smooth, resistant to distortion and impact, as well as metal-to-metal wear. It can only be machined by grinding. - It can be used in TIG technology for precision welding of small elements. - Possibility of hardfacing thinner elements with complex shapes. - Structurally martensite with retained austenite and chromium carbides.					
Application					
Hardfacing of mixer and ship shovels, bucket teeth and grippers of excavators, hammers and crushing jaws, etc.					
Base material					
Steels					
Cast steels					
Typical chemical composition %					
C	Si	Mn	Cr	Mo	
0,49	0,60	1,6	5,9	0,88	
Typical mechanical properties					
Hardness		57-62 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		C1 - 100% CO2 / M21 - Ar + 15 - 25% CO2 /			
Remarks		When hardfacing the base material of easily hardened steels, steels with high carbon content, steels with limited weldability, a buffer layer should be used, e.g. of material type 307.			
Welding parameters and packing					
Ø	Welding current [A]	Voltage [V]	Weight of packet [kg]		
1,2	190-300	29,5-33,5	15,0		
1,6	220-420	26-32	15,0		