

AA M37-42

CATEGORY	FCAW Flux-Cored					
TYPE	Seamless medium alloyed metal powder fluxcored wire without slag for hardfacing using Ar-Co ² mix					
APPLICATIONS	375-450 HB, hardfacing and rebuilding alloy for wornout wheels, rails, tires, conveyors, crossings, shafts, bufferlayers prior to hardfacing. excelent wear and abrasion resistance against heavy impact and shock, machinable with carbide tools.					
PROPERTIES	Due to the high resistance to cracking and excelent toughness, all weld metal requires no buffer layer except on materials considered critical. Suited for wear parts subject to heavy impact and shock. The interpass temperature should be maximum 250°C. The weld metal is machinable with carbide tip tools, hardening is possible. The maximum hardness is dependent on the base metal and is achieved already in the first layer.					
CLASSIFICATION	AWS	A 5.21:				
	EN ISO	14700: T Fe2				
	DIN	8555: MSG 5 - GF - 40 P				
SUITABLE FOR	Conveyors and transport surfaces, tires, bucket and loader teeth, cruscher jaws, Bufferlayers, crane wheels, axis, gear parts, winches etc.					
APPROVALS	CE approved					
WELDING POSITIONS:						
WELD METAL ANALYSIS %	C	Mn	Si	Cr	Mo	
	0.12	1.50	0.60	5.5	0.50	
MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V	Hardness HRC
	AW				-20°C -40°C -60°C	37-42
AW: as welded						
WELDING PARAMETERS / PACKING	Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet	
1.2	14-32	80-300	K 202	5	1000	
1.2	14-32	80-300	K 300	16	1024	
1.6	18-34	100-420	K 300	16	1024	
REDRYING TEMPERATURE	not required					
GAS ACC. EN ISO: 14175	M21					