

## AA M57-62

**CATEGORY** FCAW Flux-Cored

**TYPE** Seamless medium alloyed metal powder fluxcored wire without slag for hardfacing using Ar-Co<sup>2</sup> mix

**APPLICATIONS** Rebuilding and cladding parts against strong abrasion and heavy impact.

**PROPERTIES** Due to the high resistance to cracking and toughness, all weld metal requires no buffer layer except on materials considered critical. In this situation Ceweld ER 100 S-G is recommended. Suited for wear parts subject to heavy impact and shock. The interpass temperature should be maximum 250°C. The weld metal is machinable by special carbide tools, hardening is possible. The maximum hardness is dependent on the base metal and is achieved in the first layer.

**CLASSIFICATION**

AWS	A 5.21:
EN ISO	14700: T Fe4
DIN	8555: MSG 6 - GF - 60 P

**SUITABLE FOR** 55-62 HRc hardfacing alloy against heavy impact and shock, bucket, loaders, crusher jaws, crusher cones, pumps, sand, snow scratchers, stone cutting tools etc.

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

C	Mn	Si	Cr	Mo
0.50	1.50	0.60	6.00	0.90

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc
				-20°C	-40°C	-60°C	
AW							57-62

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) (DC+)	spool type	kg / spool	kg / pallet
1.2	14-32	80-300	D-200	5	1000
1.2	14-32	80-300	K 300	15	1024
1.6	15.8-34	100-420	K 300	15	1024

**REDRYING TEMPERATURE** not required

**GAS ACC. EN ISO:14175** M21