

AA MnCr

CATEGORY FCAW Flux-Cored

TYPE Gas shielded fluxcored welding wire for rebuilding and buffer layers before hardfacing with extreme resistance to heavy impact loads.

APPLICATIONS Rebuilding heavy steel parts, buffer layers, winches, rails, rails crossings, dredger teeth, blast furnace mantles etc..

PROPERTIES Austenitic deposit with strain hardening properties and no limmits in the number of layers. The deposit is non magnetic and can not be flame cut and is extreme resistant to heavy impact loads..

CLASSIFICATION

AWS	A 5.21:
EN ISO	14700: T Fe9-250-KNP
DIN	8555: MF 7-250-KNP

SUITABLE FOR Rebuilding wornout parts, buffer layers, rebuilding rails and or crossings, dredger teeth, blast furnace mantles, winches.

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Si	Mn	Cr	Ni	Mo	V	Fe
0,4	0,4	16,0	14,0	1,2	0,6	0,2	Rem

MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
AW							220-250
SH							450-570

AW: as welded SH: after strain hardening

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Packing	
	Voltage (V) (DC+)	Current (A)	spool type	kg / spool
1.2	18-24	140-200	S-300	15
1,6	20-26	160-220	S-300	15

REDRYING TEMPERATURE 150°C / 24hr.

OTHER DELIVERY FORMS Open arc wire (selfshielded), SAW (Submerged arc)