

OA Mn18Cr

CATEGORY FCAW Flux-Cored

TYPE Tubular wire weldable without protective gas for rebuilding and buffer layers before hardfacing with extreme resistance to heavy impact loads.

APPLICATIONS Rebuilding, buffer layers, rails, rails crossings, dredger teeth, blast furnace mantles etc..

PROPERTIES Austenitic deposit with strain hardening properties and no limits in the number of layers. The deposit is non magnetic and can not be flame cut or machined.

CLASSIFICATION

AWS	A 5.21:
EN ISO	14700: T Fe9
DIN	8555: MF 7-300-KNP

SUITABLE FOR Rebuilding, buffer layers, rails, rails crossings, dredger teeth, blast furnace mantles etc.

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cr	Ni	Mo	Mn
1.0	18	0.5	14	1.2	0.2	0.2

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC
				-20°C	-40°C	-60°C	
AW							25-30
SH							45-50

AW: as welded, SH: after strain hardening

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Packing	
	Voltage (V)	Current (A)	spool type	kg / spool
1.6	24-35	150-350	S-300 / Drums	15 / 250
2.0	26-35	200-400	S-300 / Drums	15 / 250
2.4	26-35	250-450	S-300 / Drums	15 / 250
2.8	28-35	250-450	S-300 / Drums	15 / 250

REDRYING TEMPERATURE 150°C / 24hr.