

OA MnCr

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 heavy steel parts, 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.

CLASSIFICATION

AWS	A 5.21:
EN ISO	14700: T Fe 9
DIN	8555: MF 7-250-KNP

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

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Cr	Si	Ni	Mo	V	Fe
0.4-0.5	15-16.4	14-15.5	0.3-0.5	1-1.5	0.5-0.6	0.2-0.3	Bal.

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							Circa 500

AW: as welded SH: after strain hardening

WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool / drum
1.6	20-26	160-260	S-300 / Drum	15 / 250
2.0	22-26	240-280	S-300 / Drum	15 / 250
2.4	24-27	280-340	S-300 / Drum	15 / 250
2.8	25-28	320-400	S-300 / Drum	15 / 250

REDRYING TEMPERATURE 150°C/24hr