

Prepared by David P	Qualified by Siva P	Approved by Umesh M	Reg no EN2020041	Cancelling EN2020040	Reg date 2024-08-15	Page 1 (2)
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GENERAL

Self-shielded flux-cored continuous wire for low stress abrasive wear and metal-to-metal friction. Wear protection of mild steel, low alloy steel and manganese steel. Track shoes, conveyor chains, crusher hammers, bucket teeth, shear knives, shovels, excavating equipment, tampers, gyratory crushers, screw conveyors, coal chutes, anvil plates, press rolls, etc.

Polarity: DCEP

Alloy Type : Fe based alloy

Flux Type : Basic

WELDING POSITIONS



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CLASSIFICATIONS Electrode

EN14700 : TFe2

APPROVALS

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max	Nom
C	0.4	0.8	0.45
Si	0.1	0.8	0.6
Mn	0.5	1.5	1.1
Cr	5.0	7.0	6.1
Mo	0.5	0.8	0.7
V	0.1	0.6	0.4
Fe	-	-	Balance

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MECHANICAL PROPERTIES OF WELD METAL

Hardness	Min	Max	Nom
As-deposited hardness	57 HRC	62 HRC	60 HRC

Comments:

ECONOMICS & CURRENT DATA

Wire Dia (mm)	Voltage (V)	Current (A)	Stick-out (mm)
1.60	24-28	160-300	35 - 45

OTHER DATA

- . Clean weld area. Remove fatigued and worn-out materials. Pre-heat if required. 12-14% Mn-steel should be welded in cold condition and temperature should not exceed 150 Deg C. Avoid excessive heating of base material. Chip slag and remove residues for every pass. Allow natural cooling.
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