

Fluxofil 50 is a seamless copper coated basic flux cored wire for the hardfacing of wear components subjected to heavy impact such as pulleys, rollers, caterpillar track rollers, sprockets, track links, etc. The weld metal is of medium hardness and machinable by chip-forming. Flame and inductive hardening are feasible. Before depositing the final pass, the interpass temperature should not exceed 250 °C. Due to the very tough and crack-resistant weld metal, a buffer layer is not normally necessary.

Classification	
DIN	8555: MSG 1-GF-M21-250
DIN	8555: MSG 1-GF-C1-250

Approvals	Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
0.17	1.40	0.45	-	-	0.70	-	-	-	-	-	-


All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J)	Hardness
As Welded	-	-	-	-	225-275 HB

Gas test: Acc. To EN 439: C1(Arcal 2)

Shielding Gas: Acc. To EN 439: C1(Arcal 2) or M21(Arcal21-Atal6)

Storage
Keep dry and avoid condensation

Current condition and welding position
DC+


Packaging data: K300 kg, 16

Diameters	1,4	1,6	2,0	2,4		