

FLUXOFIL 51

Cored Wires Hardfacing

Fluxofil 51 is a seamless copper coated basic flux cored wire for hardfacing of wearing parts subjected to heavy impact such as pulleys, railway crossings and switch points, rollers, caterpillar track, sprockets, track links. The weld metal is of medium hardness and is machinable by chip-forming. Flame and inductive hardening are possible. 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 required.

| Classification | |
|----------------|------------------------|
| DIN | 8555: MSG 1-GF-M21-300 |
| DIN | 8555: MSG 1-GF-C1-300 |

| Approvals | Grades |
|-----------|--------|
| DB | |

see Appendix, Classification Society Approvals, for details pag. 521

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

| C | Mn | Si | P | S | Cr | Ni | Mo | Nb | Fe | W | Cu |
|------|------|------|---|---|------|----|----|----|----|---|----|
| 0.20 | 1.50 | 0.60 | - | - | 1.25 | - | - | - | - | - | - |

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 | - | - | - | - | 275-325 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 | | |
|-----------|-----|-----|-----|-----|--|--|
| | | | | | | |