

Fluxofil 52 is a seamless copper coated basic flux cored wire for hardfacing of wear parts, such as pulleys, rollers, caterpillar track rollers, sprockets. The weld metal is of medium hardness, and is machinable by chip-forming. The weld metal is tough and free of cracks and therefore resistant to shock and impact. It is suitable for flame and inductive hardening. Before depositing the final pass, the interpass temperature should not exceed 250 °C. A buffer layer, using Fluxofil 31, is only required for highly hardenable base metals.

Classification	
DIN	8555: MSG 1-GF-C1-300-P
DIN	8555: MSG 1-GF-C1-350-P

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
0.25	1.50	0.60	-	-	1.60	-	-	-	-	-	-

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	-	-	-	-	325-375 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		