

Fluxofil 56 is a seamless copper coated basic flux cored wire for the hardfacing of wear parts, such as excavator parts, scraper blades, dipper teeth, worm conveyors, beaters, crusher jaws, crusher cones, subjected to heavy wear. The weld metal is tough and free of cracks and therefore resistant to shock and impact. Machining is only possible by grinding. A tough buffer layer using Fluxofil 31 is only required with highly hardenable base metals.

Classification	
DIN	8555: MSG 6-GF-C1-55-GP
DIN	8555: MSG 6-GF-M21-55-GP

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
0.35	1.50	0.50	-	-	5.20	-	0.60	-	-	-	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J)	Hardness
As Welded	-	-	-	-	52-57 HRC

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		