

FLUXOFIL 66

Cored Wires Hardfacing

Fluxofil 66 is a seamless copper coated slagless metal cored wire for high hardness wear overlay. Suitable for roll type crushers, worm conveyors, scraper blades, dipper teeth etc. The weld metal is crack resistant and highly resistant to impact and abrasion. In the case of thick overlays, it is recommended to weld only the last two layers with Fluxofil 66 and to use Fluxofil 31 or the Ffluxofil 35 for the preceding passes. Machining by chip-forming is not possible with this weld metal. The weld deposit contains hard phases in the form of special carbides.

Classification	
EN	14700:T Z Fe8

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
1.20	1	1	-	-	6	-	0.20	7	-	0.25	-

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	-	-	-	-	57-62 HRC

Gas test: Acc. To EN 439: I1(Arcal1)

Shielding Gas: Acc. To EN 439: M21(Arcal21-Atal6) or I1(Arcal 1)

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data: K300 kg. 16

Diameters	1,6	2,4				