

## SAW Cored Wires Hardfacing

Fluxocord 51 is a seamless copper coated basic flux cored wire suitable for SAW hardfacing in combination with the flux OP 122. It is used for hardfacing rollers, caterpillar track rollers, track links, etc. The weld metal is tough and crack resistant and is suitable for hardfacing components, which are subject to heavy impact. The deposit is machinable by chip forming and flame and inductive hardening are possible.

Flux	Classification
	DIN 8555: UP1-GF-BFB1 65-300

Flux	Approvals	Grades

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

Flux	C	Mn	Si	Cr	Ni	Mo	Nb	N	Cu
OP 122	0.18	1.70	0.35	1.10	-	-	-	-	-

### All-weld metal Mechanical Properties

Flux	Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Hardness
OP 122	As Welded	-	-	-	275-325 HB

### Current condition

DC+; AC

**Packaging data:** K415 kg, 25

Diameters	2,4	3,2	4,0	5,0	