

Fluxocord 52 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, sprockets, excavator parts, etc. The weld metal is resistant to shock and impacts and is machinable up to the 3rd layer. With highly hardenable base metals a buffer layer is required, deposited with Fluxocord 31/OP 121TT.

In this case preheating in the range of 200-250°C is recommended. Suitable for flame and inductive hardening.

Flux	Classification
	DIN 3555: UP1-GF-BFB1-65-400-P

Flux	Approvals	Grades

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

Flux	C	Mn	Si	Cr	Ni	Mo	Nb	N	Cu
OP 122	0.22	1.80	0.70	1.50	-	-	-	-	-

All-weld metal Mechanical Properties

Flux	Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Hardness
OP 122	As Welded	-	-	-	375-450 HB

Current condition

DC+; AC

Packaging data: K415 kg, 25

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