

FLUXOCORD 54

SAW Cored Wires Hardfacing

Fluxocord 54 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 jackwheels, bearing surfaces, conveyor belt wheels and rolls, etc. Due to its low carbon content, the weld metal is very tough and therefore particularly resistant to shock and impact. The weld metal is machinable using carbide tipped tools. With highly hardenable base metals a buffer layer is required, deposited with Fluxocord 31/OP 121TT. Interpass temperatures up to 400°C will not considerably effect deposit hardness.

Flux	Classification
	Not Applicable

Flux	Approvals	Grades

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

Flux	C	Mn	Si	Cr	Ni	Mo	Nb	N	Cu
OP 122	0.06	1.10	0.15	4.50	-	0.50	-	-	-

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	-	-	-	34-38 HRC

Current condition

DC+; AC

Packaging data: K415 kg, 25

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