

# PRODUCT DATA SHEET

## Corewear 34-O

Corewear 34-O is a self-shielded flux cored wire for build-up or hardfacing on worn workpieces. It deposits a weld metal of medium hardness and is suitable for metal-to-metal abrasion.

### Applications

Corewear 34-O is suitable for the hardfacing of tractor rollers, shafts, gears, sprockets and mine car wheels where machining after welding is required. The preheat and interpass temperatures for large workpieces should be kept between 150-250°C to prevent weld cracking.

### Classifications

DIN	8555	MFI-GF-300-P
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### Typical Chemical Analysis (All weld metal)

% Carbon	0,16	% Chromium	1,2
% Manganese	2,0	% Aluminium	1,6
% Silicon	0,5		

### Typical Hardness

HRc	30 - 34 (3rd layer)
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### Welding Data

#### (DC+)

Diameter (mm)	Current		Wire Stick Out
	Amps (A)	Volts (V)	
2,4	250 - 400	25 - 32	50 - 60

### Packing Data

Diameter (mm)	Spool Mass (kg)	Spool Type	Item Number
2,4	25,0	Wire Basket	W077081

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