

COREWEAR 56-O

Corewear 56-O is a self-shielded flux cored wire with a deposited hardness of about HRc 56. It provides excellent abrasion resistance and moderate impact resistance. A deposit thickness of two layers is recommended to prevent weld cracking. The deposit will workharden by 3 HRc

APPLICATIONS

Corewear 56-O is suitable for the hardfacing of Buckets, dipper teeth, pulveriser rings and other parts subject to severe wear.

The pre-heat and interpass temperatures for large workpieces should be kept between 200-250°C to prevent weld cracking.

SPECIFICATION

DIN 8555 MF6-GF-55-G

TYPICAL WELD METAL DATA

%C	%Mn	%Si	%Cr	%Mo	%Al
0.8	1.45	0.56	5.45	0.91	1.50

TYPICAL HARDNESS RANGE HRc

50-59 HRc 3rd Layer

RECOMMENDED WELDING DATA

Corewear 56-O can be welded on DCEP

Dia mm	Current	Volts	Electrode Stickout
2.4	280-340	27-28	40-50
2.8	350-400	27-28	50-70

PACKAGING DATA

Dia mm	Item Number	Spool Mass Kg	Spool Type
2.4	077314	25	Wire Basket
2.8	077318	25	Wire Basket
2.8	077319	250	Drum

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