OK Autrodur 56 G M

A copper coated, low-alloyed solid GMAW wire used for hard facing and building up highly wear resistant layers on tools and machinery parts, driving rollers, digging tools etc. The hardness of the weld metal becomes 50-60 HRC.

Classifications	EN 14700 : Fe8

Alloy Type	Low alloyed (0.45 % C, 3 % Si, 9 % Cr)

Typical Weld Metal Analysis %					
C	**Mn**	**Si**	**S**	**P**	**Cr**
Shielding gas: CO2					
0.4	0.3	2.6	0.01	0.02	8.8
Shielding gas: 80Ar/20CO2					
0.4	0.3	2.7	0.01	0.02	9.0

Typical Wire Composition %			
C	**Mn**	**Si**	**Cr**
0.44	0.4	3.02	9.24

Deposition Data				
Diameter	**Current**	**Voltage**	**Wire Feed Speed**	**Deposition Rate**
1.0 mm	80-280 A	18-28 V	2.7-14.7 m/min	1.0-5.4 kg/h
1.2 mm	120-350 A	20-33 V	2.7-12.4 m/min	1.5-6.6 kg/h
1.6 mm	225-480 A	26-38 V	3.1-8.1 m/min	3.3-0.0 kg/h

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