MEGAFIL® A 760 M

EN ISO 14700: T Fe2

WELDING POSITIONS:

FEATURES	BENEFITS	APPLICATIONS
• Well suited for wear resisting parts subject to heavy impact • Good reignition characteristics • Virtually no slag coverage • Smooth arc characteristic	• No buffer layer except on materials considered critical • Machinable weld metal • Hardening possible • No re-drying • Suitable for robot applications	• Automatic and mechanized welding • Bucket and loader teeth • Conveyors • Crusher jaws and cones

WIRE TYPE	Gas shielded metal-cored wire
SHIELDING GAS	75-85% Argon (Ar)/Balance Carbon Dioxide (CO_2); Gas flow 12-18 l/min
TYPE OF CURRENT	Direct Current Electrode Positive (DCEP)
STANDARD DIAMETERS	Ø 1.2 - 1.6 mm (0.045 - 1/16˝)
RE-DRYING	Not required due to seamless wire design
STORAGE	The same conditions as for solid wire. Product should be stored in a dry, enclosed environment, in its original undamaged packaging

WELD METAL ANALYSIS (%) (typical values for mixed gas 82% Ar / 18% CO_2)

Carbon (C)	0.5	Nickel (Ni)	-
Manganese (Mn)	1.5		
Silicon (Si)	0.6		
Chromium (Cr)	6.0		
Molybdenum (Mo)	0.5		

HARDNESS OF PURE WELD METAL FROM THE 3rd LAYER (typical values for mixed gas 82% Ar / 18% CO_2)

Hardness Rockwell (HRC)	55 - 65	The achieved hardness as well as the structure of the hardfacing depends on (among others): Base material, welding parameters, working and interpass temperature, heating up, cooling down, number of layers, hardfacing methods and shape of component.