

MIG/MAG Cored Wires Hardfacing

FLUXOFIL 51 is a seamless copper coated basic flux cored wire for hardfacing of wearing parts subjected to heavy impact such as pulleys, railway crossings and switch points, rollers, caterpillar track, sprockets, track links. The weld metal is of medium hardness and is machinable by chip-forming. Flame and inductive hardening are possible. Before depositing the final pass, the interpass temperature should not exceed 250 °C. Due to the very tough and crack-resistant weld metal, a buffer layer is not required.

Class	ification	
EN	14700: T Fe1	

Chemical analysis (Typical values in %)

C	Mn	Si	Cr
0.2	1.6	0.6	1.4

All-weld metal Mechanical Properties

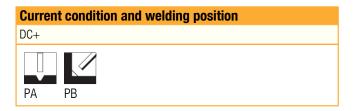
Heat Treatment	Hardness
As Welded	275-325 HB

Gas test: 100% CO2

Shielding Gas - EN ISO 14175 : C1

Storage

Keep dry and avoid condensation



Packaging data

Packaging Type	B300
Diam(mm) / weight(kg)	16.0
1.2	W000281338
1.4	W000281339
1.6	W000281340
2.0	W000281342
2.4	W000281343

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