

FLUXOFIL 54 is a seamless copper coated basic flux cored wire for hardfacing deposits having high wear resistance, such as excavator parts and bearing surfaces. Due to the low carbon content, the weld metal is very tough and therefore particularly resistant to heavy shock and impact. Machining by chip-forming is possible using carbide-tipped or hard metal cutting tools. A buffer layer, using FLUXOFIL 31, is only required in case of difficult-to-weld steels. When hardfacing unalloyed base metal, maximum hardness of the deposit is obtained in the first layer. Before depositing the final layer in multi-layer welds, the interpass temperature should not exceed 250 °C.

Classification

EN 14700: T Z Fe7

Chemical analysis (Typical values in %)

C	Mn	Si	Cr	Mo
0.07	1.6	0.3	6	0.9

All-weld metal Mechanical Properties

Heat Treatment	Hardness
As Welded	37-42 HRC

Gas test: 100% CO₂

Shielding Gas - EN ISO 14175 : C1

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



PA PB

Packaging data

Packaging Type	B300
Diam(mm) / weight(kg)	16.0
1.4	W000281347
1.6	W000281348