WEARcore Tool 58 TiC-O (SK 258 TIC-O)

open arc flux cored wire

Classifications

EN 14700	DIN 8555
T Z Fe6	MF 6-GF-60-GP

Characteristics

Martensitic Chromium-Titanium alloy designed to resist high stress abrasion with heavy impact. Deposits usually do not relieve cracks.

Microstructure:	Finely dispersed Titanium carbides in a hard Chromium martensitic matrix
Machinability:	Grinding only
Oxy-acetylene cutting:	Cannot be flame cut
Deposit thickness:	15 to 18 mm in 5 to 6 layers

Field of use

Crusher rollers, crusher hammers, asphalt mixer blades, agricultural tools, shovel bucket teeth and lips, bulldozer blades, cane knives and shredders, bed knives in the wood pulp industry.

Typical analysis in %

C	Mn	Si	Cr	Mo	Ti	Fe
1.8	0.9	0.2	6.1	1.4	5.5	balance

Typical mechanical properties

Hardness as welded: 58 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.2	120 – 150	26 – 30	35 – 40
1.6	180 – 200	26 – 30	35 – 40
2.0	200 – 280	26 – 30	35 – 40
2.4	250 – 300	26 – 30	35 – 40
2.8	300 – 350	26 – 30	35 – 40