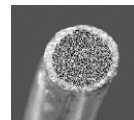




Seamless metal-cored wire for MAG hardfacing

MEGAFIL[®] A 864 M



- Type:** High-alloy metal cored wire for hardfacing using Ar-CO₂ mix.
Can also be used without shielding gas.
- Applications:** Repair of equipment used in mining and steel mills. Hardfacing equipment and tools used in the construction and agriculture industries. Highway construction equipment, and conveyor chains, mixing paddles, cement pumps components, etc.
- Properties:** The hardfacing contains sufficient special carbides formed with boron and therefore has excellent resistance to abrasion from sand and minerals.
The weld metal is machinable only by grinding. Stringer bead technique is recommended.
The hard surfacing contains check cracks, but this does not impair wear resistance.

Classification: EN 14700 T Fe13

Weld metal analysis % (typical values for mixed gas M21 82% Ar / 18% CO₂)

C	Mn	Si	Cr	B	Ni
0,5	1,1	0,3	0,3	4,8	1,5

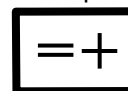
Hardness of pure weld metal from the 2nd layer:

60 - 68 HRC Hardness Rockwell

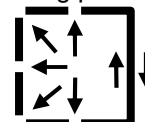
The achieved hardness as well as the structure of the hard facing depend on (among others):
Base material, welding parameters, working and interpass temperature, heating up, cooling down, number of layers, hardfacing methods and shape of component.

- Diameters:** Ø ≥ 1,2 mm (0.045 inch)
- Packaging:** The same conditions as for solid wire.
Product should be stored in a dry, enclosed environment, and in its original intact packing
for detailed information please call us

current / polarity



welding position



Disclaimer: Whilst all reasonable efforts have been made to ensure the accuracy of the information contained, the information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and any liability incurred from any reliance thereon is expressly disclaimed. Typical data are those obtained when welded and tested in accordance to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Other tests and procedures may produce different results. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application. The selection and use of specific products is solely within the control of, and remains the sole responsibility of the customer. The right to change design and/or specifications without notice is reserved.