

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.

Classification

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

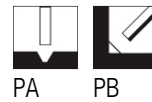
Shielding Gas - EN ISO 14175 : C1

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



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