

OK Autrodur 56 G M

A copper coated, low-alloyed solid GMAW wire used for hard facing and building up highly wear resistant layers on tools and machinery parts, driving rollers, digging tools etc.

The hardness of the weld metal becomes 50-60 HRC.

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| Classifications Wire Electrode | EN 14700 : Fe8 |
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|---------------|--|
| Typ zliatiny | Low alloyed (0.45 % C, 3 % Si, 9 % Cr) |
| Ochranný plyn | M21, C1 (EN ISO 14175) |

Typical Weld Metal Analysis %

| C | Mn | Si | S | P | Cr |
|-----|-----|-----|------|------|-----|
| 0.4 | 0.3 | 2.7 | 0.01 | 0.02 | 9.0 |

Typical Wire Composition %

| C | Mn | Si | Cr |
|------|-----|------|------|
| 0.44 | 0.4 | 3.02 | 9.24 |

Naváracie údaje

| Priemer | Prúd, A | V | Rýchlosť podávania drôtu | Výkon odtavenia |
|---------|-----------|---------|--------------------------|-----------------|
| 1.0 mm | 80-280 A | 18-28 V | 2.7-14.7 m/min | 1.0-5.4 kg/h |
| 1.2 mm | 120-350 A | 20-33 V | 2.7-12.4 m/min | 1.5-6.6 kg/h |
| 1.6 mm | 225-480 A | 26-38 V | 3.1-8.1 m/min | 3.3-0.0 kg/h |