

MEGAFIL[®] A 760 M



EN ISO 14700: T Fe2

WELDING POSITIONS:



FEATURES

- Well suited for wear resisting parts subject to heavy impact
- Good reignition characteristics
- Virtually no slag coverage
- Smooth arc characteristic

BENEFITS

- No buffer layer except on materials considered critical
- Machinable weld metal
- Hardening possible
- No re-drying
- Suitable for robot applications

APPLICATIONS

- Automatic and mechanized welding
- Bucket and loader teeth
- Conveyors
- Crusher jaws and cones

WIRE TYPE

Gas shielded metal-cored wire

SHIELDING GAS

75-85% Argon (Ar) / Balance Carbon Dioxid (CO₂); Gas Flow 12-18 l/min (25-38 cfm)

TYPE OF CURRENT

Direct Current Electrode Positive (DCEP)

STANDARD DIAMETERS

Ø 1.2 - 1.6 mm (0.045 - 1/16")

RE-DRYING

Not required due to seamless wire design.

STORAGE

The same conditions as for solid wire. Product should be stored in a dry, enclosed environment, in its original undamaged packaging

WELD METAL ANALYSIS (%) (typical values for mixed gas 82% Ar / 18% CO₂)

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Carbon (C)	0.5	Nickel (Ni)	-
Manganese (Mn)	1.5		
Silicon (Si)	0.6		
Chromium (Cr)	6.0		
Molybdenum (Mo)	0.5		

HARDNESS OF PURE WELD METAL FROM THE 3rd LAYER (typical values for mixed gas 82% Ar / 18% CO₂)

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Hardness Rockwell (HRC)	55 - 65	The achieved hardness as well as the structure of the hardfacing depends on (among others): Base material, welding parameters, working and interpass temperature, heating up, cooling down, number of layers, hardfacing methods and shape of component.