

MEGAFIL[®] A 864 M



EN ISO 14700: T Fe13

WELDING POSITIONS:



FEATURES	BENEFITS	APPLICATIONS
<ul style="list-style-type: none"> • Special boron based carbides • Good reignition characteristics • Virtually no slag coverage • Smooth arc characteristics • Weld metal machinable only by grinding • Sporadic cracks on the surface do not affect wear resistance 	<ul style="list-style-type: none"> • Excellent resistance to abrasion from sand and minerals • No re-drying • Suitable for robot applications • Welding without shielding gas possible 	<ul style="list-style-type: none"> • Automatic and mechanized welding • Repair of mining and steel mill equipment • Parts subject to wear in agricultural industry • Conveyors • Cement and concrete pumps

WIRE TYPE	Gas shielded metal-cored wire
SHIELDING GAS	75-85% Argon (Ar) / Balance Carbon Dioxid (CO ₂); Gas Flow 12-18 l/min (25-38 cfh)
TYPE OF CURRENT	Direct Current Electrode Positive (DCEP)
STANDARD DIAMETERS	Ø 1.2 and 1.6 mm (0.045 and 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)

Carbon (C)	0.5	Nickel (Ni)	1.5
Manganese (Mn)	1.1	Molybdenum (Mo)	-
Silicon (Si)	0.3		
Chromium (Cr)	0.3		
Boron (B)	4.2		

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

Hardness Rockwell (HRC)	60 - 70	The achieved hardness as well as the structure of the hardfacing depends an (among others): Base material, welding parameters, working and interpass temperature, heating up, cooling down, number of layers, hardfacing methods and shape of component.
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