

Fluxofil 54 is a seamless copper coated basic flux cored wire for hardfacing deposits having high wear resistance, such as excavator parts and bearing surfaces. Due to the low carbon content, the weld metal is very tough and therefore particularly resistant to heavy shock and impact. Machining by chip-forming is possible using carbide-tipped or hard metal cutting tools. A buffer layer, using Fluxofil 31, is only required in case of difficult-to-weld steels. When hardfacing unalloyed base metal, maximum hardness of the deposit is obtained in the first layer. Before depositing the final layer in multi-layer welds, the interpass temperature should not exceed 250 °C.

Classification	
DIN	8555: MSG 5-GF-M21-40-P
DIN	8555: MSG 5-GF-C1-40-P

Approvals	Grades

### Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
0.10	1.50	0.60	-	-	5.50	-	0.90	-	-	-	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J)	Hardness
As Welded	-	-	-	-	37-42 HRC


Gas test: Acc. To EN 439: C1(Arcal 2)

**Shielding Gas:** Acc. To EN 439: C1(Arcal 2) or M21(Arcal21-Atal6)

### Storage

Keep dry and avoid condensation

### Current condition and welding position

<b>DC+</b>


**Packaging data:** K300 kg. 16

Diameters	1,4	1,6	2,0	2,4		
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