

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.

Specifications

Classifications	EN 14700 : Fe8
Alloy Type	Low alloyed (0.45 % C, 3 % Si, 9 % Cr)
Shielding Gas	M21, C1 (EN ISO 14175)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Cr
Shielding gas: 80Ar/20CO ₂					
0.4	0.3	2.7	0.01	0.02	9.0
Shielding gas: CO ₂					
0.4	0.3	2.6	0.01	0.02	8.8

Typical Wire Composition %

C	Mn	Si	Cr
0.44	0.4	3.02	9.24

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm (0.040 in.)	80-280 A	18-28 V	2.7-14.7 m/min (106-579 in./min)	1.0-5.4 kg/h (2.2-11. lbs/h)
1.2 mm (0.047 in.)	120-350 A	20-33 V	2.7-12.4 m/min (106-488 in./min)	1.5-6.6 kg/h (3.3-14. lbs/h)