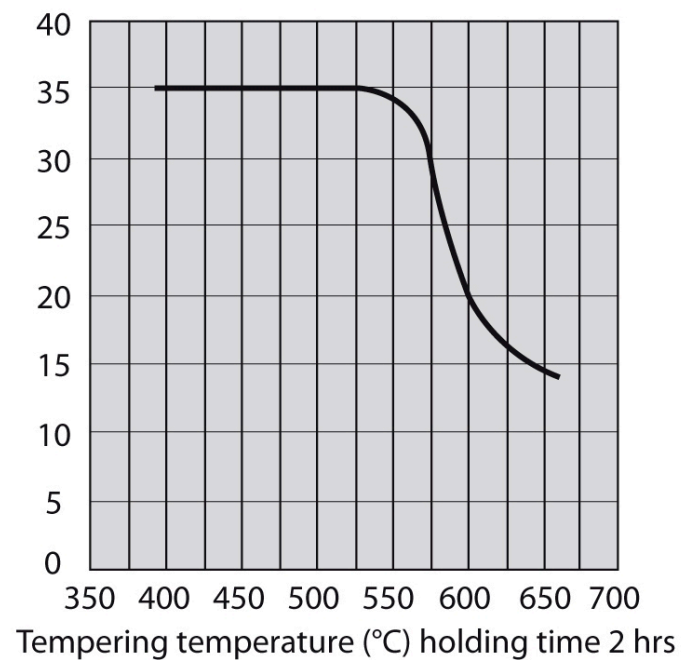
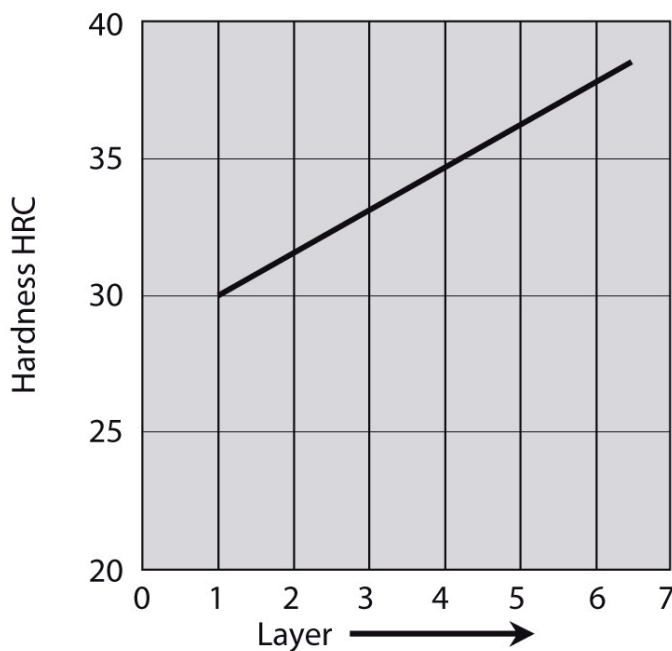


FLUXOCORD 54 is a seamless copper coated basic flux cored wire suitable for SAW hardfacing in combination with the flux OP 122. It is used for hardfacing rollers, caterpillar track jackwheels, bearing surfaces, conveyor belt wheels and rolls, etc. Due to its low carbon content, the weld metal is very tough and therefore particularly resistant to shock and impact. The weld metal is machinable using carbide tipped tools. With highly hardenable base metals a buffer layer is required, deposited with FLUXOCORD 31/OP 121TT. Interpass temperatures up to 400°C will not considerably effect deposit hardness.

Classification		
OP 122	EN	14700: ~T Fe2
OP 122	DIN	8555: UP5-GF-BFB4 652-350 GP

Weld metal hardness of tubular cored electrode

FLUXOCORD 54



Chemical analysis (Typical values in %)

		C	Mn	Si	Cr	Mo
All weld metal	OP 122	0.06	1.1	0.15	4.5	0.5

All-weld metal Mechanical Properties

	Heat Treatment	Hardness
OP 122	As Welded	34-38 HRC

Current Conditions

AC; DC+

Packaging data

Packaging Type	B450	DRUMXCL
Diam(mm) / weight(kg)	25	250
2.4	W000282338	●
3.2	W000282340	●
4.0	W000282342	●