

FLUXOFIL 52 is a seamless copper coated basic flux cored wire for hardfacing of wear parts, such as pulleys, rollers, caterpillar track rollers, sprockets. The weld metal is of medium hardness, and is machinable by chip-forming. The weld metal is tough and free of cracks and therefore resistant to shock and impact. It is suitable for flame and inductive hardening. Before depositing the final pass, the interpass temperature should not exceed 250 °C.

A buffer layer, using FLUXOFIL 31, is only required for highly hardenable base metals.

### Classification

EN 14700: T Fe1

### Chemical analysis (Typical values in %)

C	Mn	Si	Cr
0.25	1.5	0.4	1.8

### All-weld metal Mechanical Properties

Heat Treatment	Hardness
As Welded	325-375 HB

Gas test: 100% CO<sub>2</sub>

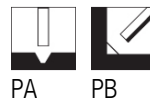
### Shielding Gas - EN ISO 14175 : C1

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC+



### Packaging data

Packaging Type	B300
Diam(mm) / weight(kg)	16.0
1.4	W000281344
1.6	W000281345