Product Data Sheet

E Self-Shielded Flux Cored welding Wire'

EWAC O-517

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GENERAL

EWAC O-517 is an open arc self-shielded flux cored wire for hard-facing against abrasion combined with pressure & impact. Weld metal microstructure consists of very fine titanium carbides uniformly dispersed in a tough austenitic matrix. Therefore, thick & multi-pass protective coating can be applied without fear of peel-off.

Typical applications include multi-pass layers and anti-wear coating on roller press rolls, crushers, tie tamping tools, cane knives, shredders, shovel buckets, augers & scraper blades etc.

Polarity: DCEP

Alloy Type : Fe alloy

Flux Type : Basic

WELDING POSITIONS



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CLASSIFICATIONS Electrode

EN 14700 : TFe8

DIN 8555 : MF 6 GF 60 GT

APPROVALS

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max	Nom
C	1.0	2.0	1.6
Si	0.1	1.0	0.6
Mn	0.5	1.5	1.0
Cr	4.0	6.0	5.1
Ti	4.0	6.0	5.2
Fe	-	Balance	Balance

MECHANICAL PROPERTIES OF WELD METAL

Hardness	Min	Max	Nom
As-Deposited (3 layers)	55 HRC	60 HRC	57 HRC

Comments:

Interpass temperature < 150 °C.

ECONOMICS & CURRENT DATA

Dia (mm)	Current (A)	Voltage(V)	Stick-Out (mm)	Shielding Gas
Ø 1.60	200-300	26-30	30 – 40	Not Required
Ø 2.40	280-350	28-32	35 – 45	
Ø 2.80	300-400	28-32	35 - 45	

OTHER DATA

After striking arc, weld with recommended electrical stick-out. For optimum deposit quality use stringer bead or moderate weaving technique. Break arc by rapidly lifting the torch away from the work piece. Clean slags between passes.

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