Fluxes for Wear Resistant and Hardsurfacing Applications

AMA OP 250 A

Standards: EN 760 SA CS 3 97 AC
DIN 32 522 B CS 3 97 CCrMo AC 8

Type/ Characteristics: Agglomerated alloy-bearing type flux for hard surfacing purposes, to be used in combination with 50-11 wire electrode. The alloying effect of the flux depends to a large degree on the welding parameters chosen. Optimum parameters for a 4 mm dia. wire electrode are 600A / 32V / 50 cm/min.
AMA OP 250 A is suitable to be used on either DC or AC. Damp flux shall be redried by baking at 300+ ˚C.

All-Weld metal analysis (typical values):

	Weight-%				
With Wire electrode	C	Si	Mn	Cr	Mo
50-11	0.15	0.5	1.5	1.5	0.02

Mechanical properties of all-weld metal (typical values) :

Wire electrode	Hardness HB 30*
50-11	250 - 350

* as to DIN 8555, sheet2, fig.2

Application: Hard surfacing of machine parts, driving gears, rails, support, rolls of caterpillars, etc.

AMA OP 350 A

Standards: EN 760 SA CS 3 97 AC
DIN 32 522 B CS 3 97 CCrMo AC 8

Type/ Characteristics: Agglomerated alloy-bearing type flux for hard surfacing purposes, to be used in combination with 50-11, 50-22 wire electrodes. The alloying effect of the flux depends to a large degree on the welding parameters chosen. Optimum parameters for a 4 mm dia. wire electrode are 600A / 32V / 50 cm/min. welding speed. AMA OP 350 A is suitable to be used on either DC or AC. Damp flux shall be redried by baking at +300 ˚C

All-Weld metal analysis (typical values):

	Weight-%				
With Wire electrode	C	Si	Mn	Cr	Mo
50-11	0.25	0.5	1.7	3	0.4
50-22	0.25	0.8	1.8	3.5	0.7

Mechanical properties of all-weld metal (typical values) :

Wire electrode	Hardness HB 30*
50-11	350 - 450
50-22	460 - 540

* as to DIN 8555, sheet2, fig.2

Application: Hard surfacing of coupling, piston rod ends and earth moving equipment.