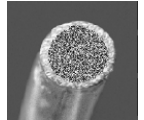




Seamless flux cored wire

STEIN-MEGAFIL[®] A 760 M



Type: Medium-alloy metal cored wire for hardfacing using Ar-CO₂ mix.

Applications: Bucket and loader teeth, conveyors, crusher jaws, crusher cones, etc.

Properties: Well suited for wear resisting parts subject to heavy impact and shock. The interpass temperature should be maximum 250 °C (482 °F). The weld metal requires no buffer layer except on materials considered critical. In this situation, **STEIN-MEGAFIL[®] 731 B** is to be used as a buffer. The weld metal is machinable by carbide tools, hardening is possible.

Classification: EN 14700 T Z Fe2

Weld metal analysis % (typical values for mixed gas M21 82% Ar / 18% CO₂)

| C | Mn | Si | Cr | Mo |
|-----|-----|-----|-----|-----|
| 0,5 | 1,5 | 0,6 | 6,0 | 0,5 |

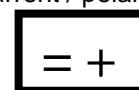
Hardness of pure weld metal (typical) from the 3rd layer:

57 - 63 HRC Hardness Rockwell

The achieved hardness as well as the structure of the hard facing depend on (among others): Base material, welding parameters, working and interpass temperature, heating up, cooling down, number of layers, hardfacing methods and shape of component.

Diameters: Ø ≥ 1,2 mm (0.045 inch)
Packaging information: see chapter H

current / polarity



welding position

