

PRECEMAY

FLUX CORED WIRE - ABRALLOY

ABRALLOY flux cored wires are available in a range of sizes, with specifications to suit all applications. Welding using wire is faster than using conventional stick electrodes due to the higher currents that can be used, therefore increasing productivity on site.

All our wires are open arc, which give greater deposition rates when welding in air rather than using a gas shield. Open arc welding does not require any separate flux and only a standard power source and wire feed unit are required. All the deposits can only be machined by grinding.

COMPARATIVE WELD METAL DEPOSITION DATA

PROCESS	SIZE MM	AMPS	VOLTS	KG/HR	ALLOY YIELD %
STANDARD EXTRUDED ELECTRODE	4	180	24	1.62	46.80
	5	250	25	2.01	46.80
HIGH RECOVERY EXTRUDED ELECTRODE	4	240	25	2.25	60.00
	5	350	26	3.50	60.00
SOLID WIRE	1.2	150-300	25-30	2.20	55.00
	1.6	200-390	25-33	3.00	55.00
FLUX CORED WIRE	1.6	150-300	25-29	3.60	60.00
	2.4	250-400	26-31	4.50	65.00
	2.8	270-450	26-31	5.50	65.50
	3.2	300-500	26-31	6.80	69.00



FLUX CORED WIRE

GRADE	DIAMETER - MM				WELD METAL ANALYSIS %										HRC	APPLICATIONS		
	1.6	2.0	2.4	2.8	C	Cr	Si	Mn	B	Mo	Nb	V	W					
AW10			✓	✓	3.5	3.5	0.3	0.4						49.0	65	Fans - Pump impellers	- Pug mills - Augers	- Feed screws - Dredger cutters
AW23			✓	✓	5.3	22.0	1.0	1.3		6.0	6.5			2.0	65	Screens - Rotating chutes	- Throat armour in blast furnaces	- Cement kilns - Sinter prongs
AW31	✓	✓	✓	✓	5.0	25.5	1.0	1.1							58	Crusher rollers - Table liners	- Mantels - Slurry pipes	- Crusher cones - Dredge pump bodies
AW31S	✓	✓	✓	✓	5.0	30.0	0.8	1.5	0.6						62			
AW31WP	✓	✓	✓	✓	5.4	28.3	1.2	0.4							58	As above plus chromium carbide plate manufacturers. Used extensively in fabrications.		
AW37	✓	✓	✓	✓	5.0	21.5	0.8	1.5		6.3					60 / 64	Wing hammers - Shovel teeth	- Mixer blades - Crusher jaws	- Breaker bars
AW58	✓	✓	✓	✓	5.0	15.5	1.0	1.1							58 / 60	Crusher parts - Conveyor screws	- Augers - Bucket lips	- Agricultural parts
AW60	✓	✓	✓	✓	0.6	6.3	0.7	1.8					0.8		55 / 60	Cutting edges - Drive tumblers	- Shovel undersides - Bucket teeth / lips	- Road construction equipment
AW108	✓	✓	✓	✓	0.4	14.1	0.7	14.0							22 / 30	Crusher hammers - Rail points	- Crusher jaws - Bucket teeth	- Wear plate edges

PRECEMAY FZE

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