

## OK Autrodur 56 G M

A copper coated, low-alloyed solid GMAW wire used for hard facing and building up highly wear resistant layers on tools and machinery parts, driving rollers, digging tools etc. The hardness of the weld metal becomes 50-60 HRC.

### Specifications

<b>Classifications</b>	EN 14700 : Fe8
<b>Alloy Type</b>	Low alloyed (0.45 % C, 3 % Si, 9 % Cr)

### Typical Weld Metal Analysis %

C	Mn	Si	S	P	Cr
<b>Shielding gas: CO2</b>					
0.4	0.3	2.6	0.01	0.02	8.8
<b>Shielding gas: 80Ar/20CO2</b>					
0.4	0.3	2.7	0.01	0.02	9.0

### Typical Wire Composition %

C	Mn	Si	Cr
0.44	0.4	3.02	9.24

### Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm	80-280 A	18-28 V	2.7-14.7 m/min	1.0-5.4 kg/h
1.2 mm	120-350 A	20-33 V	2.7-12.4 m/min	1.5-6.6 kg/h
1.6 mm	225-480 A	26-38 V	3.1-8.1 m/min	3.3-0.0 kg/h