

Meltolit

755 ECO



EN 14700 T Fe2

DESCRIPTION

Meltolit 755 ECO is a seamless copper coated tubular wire for semi-automatic gas shielded hardfacing. The wire is chromium and nickel free allowing a safer working environment for the welder when there is no toxic CrVI in the fumes. Welding deposit consists of a martensitic matrix with finely dispersed hard carbides ensuring an optimal balance between abrasion and impact resistance. With very nice weldability this wire is a optimum solution for allround hardfacing resistant to a combination of moderate abrasion and impact.

Applications: Excavator buckets, bulldozer blades, crusher equipment, mining equipment, transport screws etc.

WELDING POSITIONS					CURRENT TYPE		GAS	
					DC(+)		M21, M12	
MECHANICAL PROPERTIES								
HARDNESS								
3 layer deposit 54-56 HRC								
TYPICAL CHEMICAL COMPOSITION(%)								
C	Si	Mn	V	Mo				
0,5	0,9	1,2	3	2,8				
PACKING INFORMATION AND WELDING PARAMETERS								
Dimension(mm)			1,2			1,6		
Spool(kg)			15			15		
Stick-out(mm)			15-30 (optimum 20)			15-30 (Optimum 25)		
Amperage(A)			100-300			150-350		
Voltage(V)			18-33			22-33		
Gas flow (l/min)			10-20			10-20		

THE ECO FRIENDLY CHOICE FOR HARDFACING