

## 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

|                 |                                        |
|-----------------|----------------------------------------|
| Classifications | EN 14700 : Fe8                         |
| Alloy Type      | Low alloyed (0.45 % C, 3 % Si, 9 % Cr) |
| Shielding Gas   | M21, C1 (EN ISO 14175)                 |

### Typical Wire Composition %

### Typical Weld Metal Analysis %

### 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    |