



AMA 512 BNM-0

DIN 8555

MF 10-GF-70-GZ

Application/properties:

AMA 512 BNM-O is a self shielded metal cored welding wire. The weld metal creates very high hardness and wear resistance in single layer deposit. Weld metal microstructure contains chromium carbo borides in addition molybdenum and niobium carbides. Also the weld metal is capable of maintaining hardness at high temperatures (Up to 700 °C).

Weld metal analysis (Wt.%):

Typical single layer weld metal analysis on plain carbon steel

C	Mn	Si	Cr	B	Nb	Mo
<3	0.7	0.5	10-12	1.5-2.5	2-3	2-3

Mechanical properties:

Typical single layer weld metal hardness on plain carbon steel

Hardness	As welded
HRC	67-70

Welding parameters:

Wire Diameter (mm)	Stick-out (mm)	Voltage (V)	Current (A)
1.60	30	24-26	250-300
2.40	30	25-28	275-400

Packing:

Wire Diameter (mm)	Weight (Kg)
1.60	15
2.40	25

Note: other weight & sizes are produced upon customer request.

Field of use:

Cement and steelmaking industries, conveyor screws, fans, wear plates.