

Technical data sheet

011121MBA

Cored Welding Wire**HARDFACE FC-O****CLASSIFICATION**

EN 14700: T Fe16

DESCRIPTION

- Tubular wire for self-shielded metal arc hardfacing
- High chromium cast iron deposit containing a high proportion of hard primary chromium carbides in a tough austenitic matrix
- The deposit is suitable for hardfacing components subject to extremely severe abrasive wear and moderate impact

APPLICATIONS

HARDFACE FC-O is used for hardfacing components undergoing wear by earth, sand and abrasives.

Examples

Gyratory crusher cones and mantles, catalyst pipes and valves, slurry pipes and valve bodies, dredge pump bodies, sand dredge parts, extruder screws, "barmac" crushers, mining and earthmoving equipment.

Relief checking is normal and does not affect the properties of the deposit. However, it is best limited to two layers unless impact loading is small. Multi-layer deposits are possible in specific applications.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr
5.2	1.5	0.8	19

Structure: primary carbides and eutectic carbides of the M_7C_3 type in an austenitic matrix

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: 3-layer deposit on mild steel: 58 – 64 HRc

CONDITIONS OF USE

Current type	Protection
DC+	Self-shielded

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	100 - 250	170	21 - 28	26	20 - 30	20
1.6	160 - 320	250	24 - 30	28	20 - 30	25
2.0	200 - 400	260	25 - 32	29	25 - 40	30
2.4	250 - 450	350	26 - 32	30	25 - 40	30
2.8	250 - 450	400	26 - 32	30	25 - 40	30
3.2	250 - 550	480	26 - 32	31	25 - 40	30

Recovery: 90 %

WELDING POSITIONS

Flat, half up, half down

PACKAGING

Diameter	≤ 2.4 mm	≥ 2.4 mm	
Standard packaging	EN ISO 544: BS 300 spool	B 450 coil	Drum
Weight	15 kg	25 kg	Up to 330 kg

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.