

CATEGORY FCAW Flux-Cored

TYPE High-alloy metal cored wire for hardfacing using Ar-CO2 mix, also without shielding gas.

APPLICATIONS Chromium free hardfacing wire for extreme abrasion. Single layer on mild steel reaches a hardness > 60HRC.

PROPERTIES The hardfacing contains sufficient special carbides formed with boron and therefore has excellent resistance to abrasion from sand and minerals. The weld metal is machinable only by grinding. Stringer bead technique is recommended. The hard surfacing contains check cracks, but this does not impair wear resistance.

CLASSIFICATION EN ISO 14700: T Fe13
DIN 8555: MF 4-GF-65-G

SUITABLE FOR Cr-free Hardfacing alloy against extreme abrasion like agricultural equipment, sand, snow scratchers, stone cutting tools and mining equipment, Highway construction equipment and conveyor chains, mixing paddles, cement pumps components, etc. 2 layer hardness : 61-68HRC.

APPROVALS No Approvals Found

WELDING POSITIONS: 

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	B
0.5	0.3	1.1	0.3	1.5	1.5	4.2

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} MPa	R _m MPa	A ₅ (%)	Hardness Rockwell C
As Welded /				Avg. 65

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A) (DC+)	SPOOL TYPE	KG / SPOOL	KG / PALLET
1.2	14-28	80-200	K-300	16	1024
1.6	19-32	100-350	K 300	16	1024

REDRYING TEMPERATURE 140°C / 24 hr

GAS ACCORDING EN 14175