

HARDFACE FC-O

CLASSIFICATION

EN 14700 T ZFe

DESCRIPTION

- Tubular wire for self-shielded metal arc hardfacing
- Chromium cast iron offering a good compromise in applications involving combined abrasion and impact
- Small diameter wires: flexibility of use with conventional medium-powered welding equipment
- The deposit contains a high proportion of hard primary chromium carbides in a tough austenitic matrix.

APPLICATIONS

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

Examples

Crushers for soft materials, shredders, chemical and food processing industries.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Fe
5.00	1.00	0.80	19.00	Rest

Structure: primary carbides and eutectic carbides of the M7C3 type in the matrix

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-Layer deposit as welded: 60 HRc

CONDITIONS OF USE

Current type	Shielding gas
DC (+)	Self shielded

OPERATING CONDITIONS

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	100 - 300	250	21 - 35	28	12 - 25	20

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.6	150 - 300	270	24 - 35	28	15 - 25	25
2.0	200 - 400	300	26 - 35	28	20 - 50	30
2.4	250 - 450	350	26 - 35	28	25 - 50	40
2.8	250 - 450	400	28 - 35	30	25 - 50	40

Recovery: > 90 %

WELDING POSITIONS

Flat, half up, half down

STANDARD DIAMETERS (mm)

1.2, 1.6, 2.0, 2.4, 2.8, 3.2

Other diameters: please consult us

PACKAGING

Diameter	2.4 mm		2.4 mm
Standard packaging [EN ISO 544]	Spool : BS 300	Coil : B 450	Drum
Weight	15 kg	25 kg	Up to 330 kg