



FCO 350

*Hardfacing tubular flux cored wire
Resistant to impact and compression*

Classification

EN 14700 : T Fe1

Description & Applications

Tubular flux cored wire for self-shielded arc hardfacing of parts subjected to impact and high compressive stresses. Low alloy Martensitic weld deposit.

Main applications: Continuous casting rollers, rack pad and rollers, crane wheels...

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	W	V	P	S	Fe
Min											
Max	0.4		4.5	3.5	3	1	1	1			Rem.
Type	0.15	0.70	1.5	2.0	0.01	0.20	0.01	0.01	0.015	0.010	Rem.

All Weld Metal Mechanical Properties

Hardness (3rd layer)
~350 HB as welded

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	100 - 300	21 - 35	12 - 25	-
	1.6	150 - 300	24 - 35	15 - 25	



FT En-CM32-240320

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