



FCO 63

*Self-shielded high Chromium
Hardfacing metal cored wire*

Classification

EN 14700 : T Fe15

Description & Applications

Tubular wire for self-shielded metal arc hardfacing. High chromium cast iron for hardfacing components subject to extremely severe abrasive wear and moderate impact. The deposits resists to fiction, mixed with choc and compression. Hardfacing in 1, 2 or 3 layers. Only machining by grinding. Austenitic matrix containing chromium carbides.

Main applications: For excavating and crashing equipment, surfacing of endless screws, mixer blades, pump bodies for abrasive materials, excavator teeth, concrete pumps, ore crushing ...

Typical Chemical Composition (%)

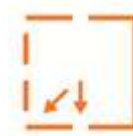
| | C | Si | Mn | Cr | Ni | Mo | Nb | P | S | Fe |
|------|-----|-----|-----|------|------|------|------|-------|-------|------|
| Min | 3 | | | 20 | | | | | | |
| Max | 7 | | 3 | 40 | 4 | 2 | 10 | | | Rem. |
| Type | 5.0 | 1.5 | 1.5 | 27.0 | 0.01 | 0.01 | 0.01 | 0.015 | 0.010 | Rem. |

All Weld Metal Mechanical Properties

Hardness (3rd layer)
~61 HRC 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-CM22-190801

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