



FCO 63Ti

*Self-shielded hardfacing wire
For abrasion and impact*

Classification

EN 14700 : T Fe8

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 and titanium 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 (%)

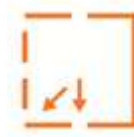
	C	Si	Mn	Cr	Mo	W	V	Nb	Ti	P	S	Fe
Min	0.2			5								
Max	2		3	20	5	2	2	10				Rem.
Type	1.8	1.2	1.2	6.5	0.80	0.01	0.01	0.01	5.0	0.015	0.010	Rem.

All Weld Metal Mechanical Properties

Hardness (3rd layer)
~57 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	140 - 230	23 - 32	25 - 50	-
	1.6	180 - 300	23 - 32	25 - 50	



FT En-CM24-200907

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.

www.fsh-welding.com - info@fsh-welding.fr