



FCO 65

*Hardfacing metal cored wire without gas
Against abrasion*

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 corrosion due to the high chromium content as well as heat up to 300°C. Hardfacing possible on 1, 2 or 3 layers. Machining only by grinding. Austenitic matrix with Chromium carbides.

Main applications: For excavating and crashing equipment, railway ballast tampers, dredge buckets and lips, dragline buckets, coke hammers, rippers, sizing screens, crushing equipment, brick industry components, Muller tires, catalyst lift pipes, pump impellers, fan blades, Rockwool rolls, wear plates operating at high temperature in the steelmaking industry

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	1.0	0.50	22.0	0.01	0.01	7.0	0.015	0.010	Rem.

All Weld Metal Mechanical Properties

Hardness (3rd layer)
62 - 65 HRC as welded

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.6	150 - 300	26 - 35	25	-

FT En-CM20-200907

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