



# FCO 67

*Self-shielded hardfacing cored wire  
For severe abrasion*

## Classification

EN 14700 : T Z Fe16

## Description & Applications

Tubular flux cored wire for self-shielded metal arc hardfacing of components subjected to several abrasions with or without shocks, at service temperature up to 650°C. Hardfacing possible in 2 or 3 layers maxi. Relief checking is normal.

**Main applications:** Ash plows, coke crusher segments, screw conveyers, valves, exhaust fans, rake teeth in furnaces ...

## Typical Chemical Composition ( % )

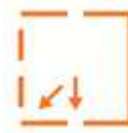
	C	Si	Mn	Cr	Nb	B	P	S	Fe
Min									
Max				Not specified					Rem.
Type	2.5	0.60	2.0	11.5	5.0	2.2	0.015	0.010	Rem.

## All Weld Metal Mechanical Properties

Hardness (3<sup>rd</sup> layer)  
64 - 68 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	100 - 300	21 - 35	12 - 25	-
	2.4	150 - 300	24 - 35	15 - 25	



FT En-CM23-180924

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