



# FCO 69

*Self-shielded hardfacing wire  
for severe abrasion*

## Classification

EN 14700 : T Fe16

## Description & Applications

Tubular flux cored wire for self-shielded metal arc hardfacing of components subjected to extremely severe abrasive wear and moderate impact. High Chromium cast iron deposit with addition of Atomic N°41 element. Weld metal deposit containing a high proportion of hard primary Chromium carbides in a tough austenitic matrix.

**Main applications:** Gyratory crusher cones and mantles, catalyst pipes and valves, slurry pipes and valve bodies, dredge pump bodies, sand dredge parts, extruder screws, mining and earthmoving equipment, blast furnace bells, brick muller tyres, crusher hammers and rolls, riddle plates, wear plates, drag line components, screw conveyors for cement, cone knives and shredders ...

## Typical Chemical Composition ( % )

	C	Si	Mn	Cr	Mo	W	V	Nb	B	P	S	Fe
Min	4			10								
Max	8		3	40	10	10	10	10				Rem
Type	4.5	1.5	0.3	26	0.05	0.01	0.05	2	0.2	0.015	0.010	Rem.

## All Weld Metal Mechanical Properties

Hardness (3<sup>rd</sup> layer)  
63 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	260	28	25	-
	2.0	300	28	30	
	2.4	350	28	40	
	2.8	400	30	40	
	3.2	450	30	40	



FT En-CM46-210302

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