FCO HBMNCR

Flux cored wire
For cavitation, abrasion and impact

Classification

EN 14700 : T Fe9

Description & Applications

Flux cored wire without gas for arc hardfacing designs to surface all pieces subject to high impact and cavitation combined with corrosion. The work hardened austenitic deposit is exceptionally resistant to wear combined to the impact. The high amount of chromium increases the resistance against the corrosion, abrasion and cavitation.

Main applications: Railway applications (rail, switches, crossing, tongues), quarries and mines (crush jaws, excavator teeth, mill hammer).

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	V	P	S	Fe
Min			9							
Max	1.2		20	20	5	2	1			Rem.
Type	0.40	0.50	16.0	14.0	0.01	0.01	0.01	0.015	0.010	Rem.

All Weld Metal Mechanical Properties

Hardness (3rd layer)	
210 - 240 HB as welded	45 – 55 HRC work hardened

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2 1.6	100 - 300 150 - 300	24 - 32 24 - 35	12 - 25 15 - 25	-