



# FCW 45

*Hardfacing metal cored wire*

## Classification

EN 14700 : T Fe1

## Description & Applications

Metal cored wire for gas shielded (Ar + CO<sub>2</sub>) arc hardfacing of unalloyed or low alloyed steels for resistance against impact and compression. Could be used as buffer layer or for rebuilt thickness of stamped mechanical components.

**Main applications:** Conveyors and transport surfaces, tires. Can be used as buffer layer prior to a higher hardness overlay.

## Typical Chemical Composition ( % )

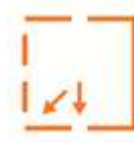
	C	Si	Mn	Cr	Ni	Mo	W	V	P	S	Fe
Min											
Max	0.4		4.5	3.5	3	1	1	1			Rem.
Type	0.35	0.60	1.4	2.5	0.01	0.50	0.01	0.01	0.015	0.010	Rem.

## All Weld Metal Mechanical Properties

Hardness (3<sup>rd</sup> layer)  
~450 HB / ~43 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	100 - 300	24 - 32	12 - 25	ISO 14175 : M21 (Ar/CO <sub>2</sub> ) 10 - 20 l/min
	1.6	150 - 300	24 - 32	12 - 25	



FT En-CM03-200624

**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](http://www.fsh-welding.com) - [info@fsh-welding.fr](mailto:info@fsh-welding.fr)