



FCW 65A

*Hardfacing metal cored wire
For extreme abrasion*

Classification

EN 14700 : T Z Fe13

Description & Applications

Seamless copper-coated tubular wire for gas shielded (Ar + CO₂) metal arc hardfacing. Weld metal deposit with Boron carbides to achieve extreme abrasion resistance. Abrasion resistance and hardness are achieved in one layer.

Could be used without shielding gas under certain condition (slight weaving technique).

Main applications: Agriculture equipment, mining, quarrying

Typical Chemical Composition (%)

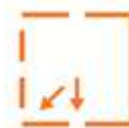
	C	Si	Mn	Ni	B	P	S	Fe
Min								
Max				Not specified				Rem.
Type	0.50	0.2	1.0	1.4	4.8	0.015	0.010	Rem.

All Weld Metal Mechanical Properties

Hardness (1st layer)
60-65 HRC as welded

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	100 - 300	21 - 35	12 - 25	ISO 14175: M20 (Ar + 5-15% CO ₂) M21 (Ar + 15-20% CO ₂) M12 (Ar + 2-5% CO ₂) M13 (Ar + 2-3% O ₂)
	1.6	150 - 300	24 - 35	15 - 25	



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