



## FCW 65BO

*Flux cored hardfacing wire  
Cr-Ni-B Alloyed  
For extreme abrasion*

### Classification

EN 14700 : T Fe15

### Description & Applications

Copper coated flux cored wire containing Chromium, Nickel and Boron for gas shielded (Ar + CO<sub>2</sub>) metal arc hardfacing. Excellent resistance against extreme abrasion. Weld deposit is not machining. Good weldability, low spatters, no slag.

**Main applications:** Agriculture equipment, mining, quarrying

### Typical Chemical Composition ( % )

	C	Si	Mn	Cr	Ni	Mo	B	P	S	Fe
Min										
Max	1.5		3	7	4	4				Rem.
Type	0.30	0.40	1.1	0.30	1.5	0.01	4.8	0.015	0.010	Rem.

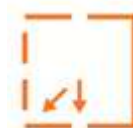
### All Weld Metal Mechanical Properties

Hardness

62 - 67 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 1.6	120 - 300 180 - 400	18 - 31 20 - 33		ISO 14175 : M21 15 - 20 l/min



FT En-CM31-190801

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