



FCW HB48HTN

*Hardfacing seamless flux cored wire
Special for hot Forging Tools*

Classification

EN 14700 : T Z Fe8

Description & Applications

Tubular flux cored wire for automatic or semi-automatic gas shielded (Ar + CO₂) arc hardfacing of hot working steels. Hardfacing parts undergoing abrasive wear, compression, and moderate impacts at high temperatures up to +550°C. Strong, tough, machinable and crack-free low alloy weld metal deposit. Mainly used to heavy build-up work in multiple layers.

Main applications: Hot forging and extrusion dies and tooling...

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Mo	Ni	Ti	P	S	Fe
Min										
Max					Not classified					Rem.
Type	0.27	0.60	0.70	9.5	2.4	3.0	0.17	0.015	0.010	Rem.

All Weld Metal Mechanical Properties

Hardness (multi-layers)	
46 - 50 HRC as welded	40 - 44 HRC after PWHT 580°C/10h

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.6	300 - 350	28 - 32	15 - 18	ISO 14175: M21 (Ar + CO ₂) 10-20 l/min

FT En-CM50-220121



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