



FCW HB50CO

*Flux cored hardfacing wire
For hot working*

Classification

EN 14700 : T Z Fe3

Description & Applications

Flux cored wire without gas for arc hardfacing. The weld deposit resists to wear at high temperature (up to 550°C), thermal shock and can be machined with tungsten carbide tipped tools. Excellent resistance against cracking.

Main applications: Extrusion pistons, valves, moulds, continuous driving rolls....

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Co	P	S	Fe
Min										
Max					Not specified					Rem.
Type	0.15	0.70	0.40	13.5	0.50	2.7	12.5	0.015	0.010	Rem.

All Weld Metal Mechanical Properties

Hardness (3rd layer)
~47 HRC as welded

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.6	100 - 300	24 - 32	12 - 25	-
	2.4	150 - 300	24 - 35	15 - 25	



FT En-CM14-190801

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