



FCW HB650HT

*Hardfacing tubular cored wire
For abrasion, friction and shocks*

Classification

EN 14700 : T Fe8

Description & Applications

Tubular cored wire for gas shielded (Ar + CO₂) arc hardfacing of components in mild steels or low alloy steels, subjected to metal/metal wear or to abrasion added or not to shocks at service temperature up to +500°C. Buffer layer on Manganese steels is advised with FCW 312. Preheating between 150 to 300°C could be necessary depending on thickness and chemical composition of base materials

Main applications: Hardfacing of trimming and blanking dies, of shear blades, of cold and hot working dies of punches, hot shearing knives, forging dies...

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Mo	W	V	Nb	P	S	Fe
Min	0.2			5							
Max	2		3	20	5	2	2	10			Rem.
Type	0.50	1.3	1.3	5.6	1.3	1.3	0.30	0.01	0.015	0.010	Rem.

All Weld Metal Mechanical Properties

Hardness (3rd layer)
57 - 62 HRC as welded

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = + / = - / pulsed	1.2 1.6	110 - 300 130 - 350	16 - 32	12 - 25	ISO 14175: M12/M13/M20/ M21 (Ar + CO ₂) 10-20 l/min

FT En-CM06-180924

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