



## FCW HBMax

*Hardfacing tubular flux cored wire  
Resistant to corrosion and metal/metal  
wear*

### Classification

EN 14700 : T Z Fe3

### Description & Applications

Tubular flux cored wire for gas shielded (Ar + CO<sub>2</sub>) arc hardfacing parts subjected to corrosion and metal/metal wear at high temperature up to +650°C.

**Main applications:** Hardfacing of hot working tools...

### 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	14.5	0.50	2.5	12.5	0.015	0.010	Rem.

### All Weld Metal Mechanical Properties

Hardness (3<sup>rd</sup> layer)

45 - 52 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	24 - 32	12 - 25	ISO 14175 : M12/M13/M20/ M21 (Ar/CO <sub>2</sub> ) 10 - 20 l/min
	1.6	150 - 300	24 - 32	12 - 25	
	2.0	200 - 400	24 - 32	12 - 30	
	2.4	250 - 450	24 - 32	12 - 30	



FT En-CM36-180925

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