FCH 360

Gas Shielded Flux Cored Welding Wire - Hardfacing Applications

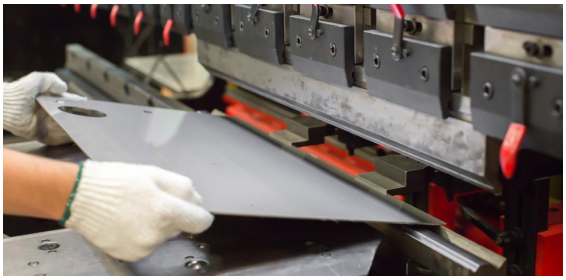
Standards

EN 14700	T Fe8
TS EN 14700	T Fe8
DIN 8555	MF 6-GF-60-GPT

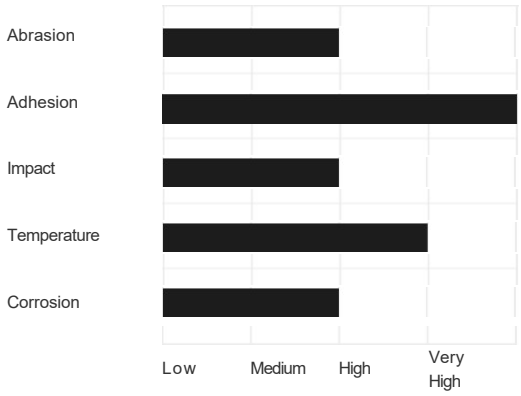
Properties and Applications

Gas shielded, high alloyed, flux cored wire designed for hardfacing deposit with high hardness. Especially developed for hardfacing of parts subjected to high metal-to-metal wear and moderate impact. Weld metal can retain its hardness at high temperatures, till 600°C. Weld metal can be grinded and machined by diamond tools. Weld metal is resistant to cracking and shall not be welded more then 3 pass. A tough buffer layer with FCW 30 is recommended before hardfacing, if base metal has high carbon and low weldability. Heat treatment after hardfacing will decrease as-welded hardness.

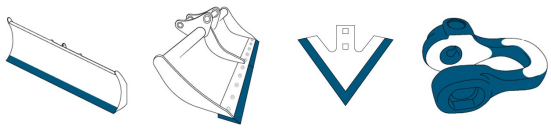
Typical Applications: Hardfacing hot cut offs, shear blades, dies for pressure casting, scraper blades, conveyors, rollers, crusher rolls and worn parts in agricultural equipments.



Wear Resistance Types



Typical Applications



Typical Chemical Values of Weld Metal

Type of Analysis	C	Si	Mn	Cr	Mo	V	Fe
Weld Deposit	0.60	0,50	0.20	5.60	0.25	0.20	92.65

Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Hardness (HRc)
As welded	C1	59

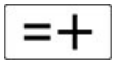
* Chemical compositon and mechanical properties are valid when using shielding gas EN ISO 14175 - C1 (%100 CO2) .

Application Information

Welding Positions

PA PB

Polarity:



Protection Gas:

M21 C1

Welding Parameters & Efficiency

Diameter (mm)	Deposition Rate(kg/h)	Efficiency(%)
1.60	5.3	92
2.40	5.99	93
1.20	4.23	95

Packaging Information

Product Code	Diameter (mm)	Pieces per Box (~)	Weight Of The Box (kg)	Boxes Per Package	Weight Of The Package	Packaging Type
38003EHAM2	1.20	15 kg	15.0	1	15.8	Plastic Spool (D300)
38003EJAM2	1.20	15 kg	15.0	1	15.7	Wire Basket Spool (K300MS)
38003GJAM2	1.60	15 kg	15.0	1	15.7	Wire Basket Spool (K300MS)
38003IXAM2	2.40	25 kg	25.0	1	25.8	Wire Basket Spool (K435)

Storage & Re-Drying Information

Shouldn t be exposed to high statical load and impact.