



# FCO 65A

*Hardfacing metal cored wire without gas  
For extreme abrasion*

## Classification

EN 14700 : T Z Fe13

DIN 8555 : MF 10-GF-65-G

## Description & Applications

Tubular wire for self-shielded metal arc hardfacing. Alloy for unalloyed steels with C <0.5% to achieve extreme abrasion resistance. Abrasion resistance and hardness are achieved in one layer

**Main applications:** Agriculture equipment, mining, quarrying

## Typical Chemical Composition ( % )

| C    | Si  | Mn  | Cr  | B   | P     | S     | Fe   |
|------|-----|-----|-----|-----|-------|-------|------|
| 0.50 | 1.3 | 2.0 | 2.0 | 4.5 | 0.015 | 0.010 | Rem. |

## All Weld Metal Mechanical Properties

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

~65 HRC as welded

## Welding Current & Instructions

| Welding mode | Wire Ø (mm) | Welding parameters |             |                | Shielding Gas |
|--------------|-------------|--------------------|-------------|----------------|---------------|
|              |             | Current (A)        | Voltage (V) | Stick out (mm) |               |
| FCAW<br>= +  | 1.2         | 100 - 300          | 21 - 35     | 12 - 25        | -             |
|              | 1.6         | 150 - 300          | 24 - 35     | 15 - 25        |               |

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