



# FCO 66

*Self-shielded hardfacing wire  
for severe abrasion*

## Classification

EN 14700 : T Fe16

## Description & Applications

Tubular flux cored wire for self-shielded metal arc hardfacing of components subjected to several abrasions with or without shocks, at service temperature up to 600°C. Hardfacing possible in 2 or 3 layers maxi. Relief checking is normal.

**Main applications:** Ash plows, coke crusher segments, screw conveyers, valves, exhaust fans, rake teeth in furnaces ...

## Typical Chemical Composition ( % )

C	Si	Mn	Cr	Nb	Mo	W	V	P	S	Fe
5.5	1.5	0.50	22.0	6.0	5.5	2.0	1.0	<0.015	<0.010	Rem.

## All Weld Metal Mechanical Properties

Hardness (3<sup>rd</sup> layer deposit)  
64 - 66 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	150 - 350	26 - 30	25 - 30	-
	2.4	250 - 450	26 - 32	25 - 40	

FT En-CM21-160404



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