



# FCO HBMnCr

*Flux cored wire  
For cavitation, abrasion and impact*

## Classification

EN 14700 : T Fe9

DIN 8555. : MF 7-GF-250

## Description & Applications

Flux cored wire without gas for arc hardfacing designs to surface all pieces subject to high impact and cavitation combined with corrosion. The work hardened austenitic deposit is exceptionally resistant to impact and wear combined to the impact. The high amount of chromium increases the resistance against the corrosion, abrasion and cavitation.

**Main applications:** Railway applications (rail, switches, crossing, tongues), quarries and mines (crush jaws, excavator teeth, mill hammer).

## Typical Chemical Composition ( % )

C	Si	Mn	Cr	P	S	Fe
0.40	0.50	16.0	14.0	0.015	0.010	Rem.

## All Weld Metal Mechanical Properties

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

210 - 240 HB as welded

45 – 55 HRC work hardened

## 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	-
	1.6	150 - 300	24 - 35	15 - 25	



FT En-CM13-160211

**Liability:** This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.

[www.fsh-welding.com](http://www.fsh-welding.com) - [info@fsh-welding.fr](mailto:info@fsh-welding.fr)