



# FCW 45

*Hardfacing metal cored wire*

## Classification

EN 14700 : T Fe2

DIN 8555 : MSG 1-GF-400

## Description & Applications

Metal cored wire for gas shielded (Ar + CO<sub>2</sub>) arc hardfacing of unalloyed or low alloyed steels for resistance against impact and compression. Could be used as buffer layer or for rebuilt thickness of stamped mechanical components.

**Main applications:** Conveyors and transport surfaces, tires. Can be used as buffer layer prior to a higher hardness overlay

## Typical Chemical Composition ( % )

C	Si	Mn	Cr	Mo	P	S	Fe
0.40	0.70	1.5	2.5	0.50	0.015	0.010	Rem.

## All Weld Metal Mechanical Properties

Hardness (3<sup>rd</sup> layer)  
~450 HB 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 : M21 (Ar/CO <sub>2</sub> ) 10 - 20 l/min
	1.6	150 - 300	24 - 32	12 - 25	

FT En-CM03-160211



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