



# FCW 65Bo

*Flux cored hardfacing wire  
Cr-Ni-B Alloyed  
For extreme abrasion*

## Classification

EN 14700 : T Fe15

DIN 8555 : MF 10-GF-65-GRZ

## Description & Applications

Copper coated flux cored wire containing Chromium, Nickel and Boron for gas shielded (Ar + CO<sub>2</sub>) metal arc hardfacing. Excellent resistance against extreme abrasion. Weld deposit is not machining. Good weldability, low spatters, no slag.

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

## Typical Chemical Composition ( % )

C	Si	Mn	Cr	Ni	B	P	S	Fe
0.30	0.40	1.1	0.30	1.5	4.8	0.015	0.010	Rem.

## All Weld Metal Mechanical Properties

Hardness

62 - 67 HRC as welded

## Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	120 - 300	18 - 31		ISO 14175 : M21 15 - 20 l/min
	1.6	180 - 400	20 - 33		

FT En-CM31-160211



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