



FCW HB50Co

*Flux cored hardfacing wire
For hot working*

Classification

EN 14700 : T Z Fe3

DIN 8555. : MSG 4-GF-45-CRTZ

Description & Applications

Flux cored wire without gas for arc hardfacing. The weld deposit resists to wear at high temperature (up to 550°C), thermal shock and can be machined with tungsten carbide tipped tools. Excellent resistance against cracking.

Main applications: Extrusion pistons, valves, moulds, continuous driving rolls....

Typical Chemical Composition (%)

C	Si	Mn	Cr	Mo	Ni	Co	P	S	Fe
0.15	0.70	0.40	14.5	2.50	0.50	12.5	0.015	0.010	Rem.

All Weld Metal Mechanical Properties

Hardness (3rd layer)

~47 HRC

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.6	100 - 300	24 - 32	12 - 25	-
	2.4	150 - 300	24 - 35	15 - 25	

FT En-CM14-160211



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