


FC 50 DC±

HARDFACING
DESCRIPTION

Chromium carbides **open arc hardfacing wire** that produces a controlled microstructure of specially sized carbides in a very tough matrix. For applications involving high impact combined with abrasion, heat or corrosion. Weld metal is tougher than conventional chromium carbide alloys with fewer stress relieving check-cracks. **Deposits are slag free and cannot be flame cut. A gas cover can be used with small diameters.**

TOTAL ALLOY CONTENT: 20 % (Carbon, Silicon, Manganese, Chromium, Molybdenum)

TYPICAL APPLICATIONS

Most applications involve high impact and crushing, such the final overlay on crusher jaws, cone and roll shell, crusher hammers, impact breaker bars and pulverizing hammers. Use on carbon and low alloys steels and on manganese steels.

PROCEDURE

When welding out of position, use .045" with reversed polarity and the lower range of amperages and voltages. Weld vertical down with 3/4" wide weave beads. A gas cover will be helpful, especially when using a constant current power source and voltage sensing feeder.

MECHANICAL PROPERTIES

Hardness (as-welded): 47 - 52 HRC
 Deposit thickness: 2 - 3 passes maximum

WELDING PARAMETERS

Diameter:	1/16" (1.6 mm)	.045" (1.2 mm)
Voltage:	20 - 28 V	15 - 26 V
Amperage:	160 - 300 A	100 - 250 A
Stick out:	1" - 1 1/2"	3/4" - 1"
Packaging:	Spool 11,4 kg	

Other diameters available on request.

Coated electrodes also available: **Selectarc HB 50**

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Specialized welding alloys and technology. For technical assistance or for ordering: