



FC 60 DC±

HARDFACING

DESCRIPTION

Hardfacing wire with gas and open arc. A general purpose flux-cored wire hardfacing overlay with good combination of abrasion resistance and impact resistance. **Selectarc FC 60** is very tough with excellent resistance to chipping and spalling. Deposits will retain their hardness and maintain a good cutting edge up to 1100°F (595°C). Use on carbon and alloy steels, manganese steels and cast iron. Deposits can be flame cut and are considered non-machinable. **Selectarc FC 60 in 1/16" (1.6 mm) diameter is open arc.**

TOTAL ALLOY CONTENT: 12 % (Carbon, Silicon, Manganese, Chromium, Molybdenum)

TYPICAL APPLICATIONS

Use on carbon and alloy steels, manganese steels and cast iron. Typical applications include tillage tools, bucket teeth, augers, screw conveyors, dozer blades and coal chutes.

MECHANICAL PROPERTIES

Hardness (as-welded): 55 - 60 HRC
 Deposit thickness: 2 - 3 passes maximum

WELDING PARAMETERS

	Short-arc		Spray-arc			Pulsed spray arc welding					
	.045"	1/16"	.045"	1/16"		Use gas 98/2 Argon/Oxygen					
						.045"	1/16"				
Amps	120-170	150-220	220-260	220-280	Current	200	220	250	250	275	300
Volts	17-22	19-22	27-30	29-31	Peak Amps	350	375	425	350	375	400
Gas	Ar/CO ₂	Ar/CO ₂	Ar/O ₂	Ar/O ₂	Volts	24	25	26	24	25	26
CFH	25-30	25-30	40-45	40-45	CFH	40-45			40-45		
Stick-out	1/2"	3/4"	5/8"	3/4"	Stick-out	5/8"			3/4"		

When welding out-of-position, use the lower ranges of voltages and amperages: 17-19V and 130-150A

Packaging: Spool of 11,4 kg

Other diameters available on request.

Coated electrodes also available: **Selectarc HB 60**

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