Selectarc

FC 63 DC±

HARDFACING

DESCRIPTION

A high carbon, chromium rich, molybdenum strengthened **open arc flux-cored hardfacing wire** that produces a dense network of wear resistant chromium carbides in a hard alloy matrix. Deposits are designed for high abrasion and abrasion combined with mild to moderate impact. Deposits polish in service and are heat resistant up to 1000°F (531°C). **Deposits are slag-free and cannot be flame cut.** Deposits will check-crack to relieve stresses. **A gas cover can be used with small diameters.**

TOTAL ALLOY CONTENT

25 % (Carbon, Silicon, Manganese, Chromium, Vanadium, Molybdenum)

TYPICAL APPLICATIONS

Use on carbon and low alloy steels, manganese steels and cast iron. Scrapper blades, road ripper teeth, bucket teeth, bucket sides and bottoms, tillage tools, auger flights, screw conveyors, mixer blades, fan blades, and coal feeder screws.

MECHANICAL PROPERTIES

Hardness (as-welded):	58 - 63 HRC
Deposit thickness:	1 - 2 passes maximum

WELDING PARAMETERS

Diameter:	1/16" (1.6 mm)	.045" (1.2 mm)
Voltage:	22 - 28 V	18 - 24 V
Amperage:	170 - 300 A	140 - 200 A
Stick out:	1″ - 1 1/2″	3/4″ - 1″

When welding out of position, use .045'' with reverse 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.

Packaging: Spool of 11,4 kg

Other diameters available on request.

Coated electrodes also available: **Selectarc HB 63**

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

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