

## FCS 345

Tozaltı Özlü Kaynak Teli - Hardfacing Applications

### Standards

EN 14700	~T Fe1
TS EN 14700	~T Fe1
DIN 8555	UP 1-GF-45-P

### Properties and Applications

Flux cored wire for submerged arc hardfacing of parts subjected to metal-to-metal friction (adhesion) and medium degree impacts. SHF 604 flux is used together with this wire for hardfacing applications. Weld metal is easily machinable by chip forming. Interpass temperature should not exceed 250°C, during welding.

**Typical Applications** : Suitable for hardfacing rollers, rolling mills, caterpillar track rolls and tracks, sprockets, shafts, crane rollers and idler and mine car wheels.



### Typical Chemical Values of Weld Metal

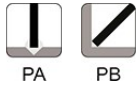
Welding Flux	Type of Analysis	C	Si	Mn	Cr	Mo	Fe
SHF 604	Weld Deposit	0.20	0.70	1.75	3.60	0.60	93.15

### Typical Mechanical Values of Weld Metal

Test Condition	Hardness (HB)
As welded	450

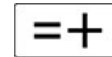
### Application Information

#### Welding Positions



PA PB

#### Polarity:



#### Welding Parameters & Efficiency

Diameter (mm)
2.40
3.20

### Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
38404I2HM2	2.40	250 kg	265.00	1	265.00	Fiber Drum
38404IXAM2	2.40	25 kg	25.80	1	25.80	Wire Basket Spool (K435)
38404L2HM2	3.20	250 kg	265.00	1	265.00	Fiber Drum
38404LXAM2	3.20	25 kg	25.80	1	25.80	Wire Basket Spool (K435)

### Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.  
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.