

FCS 355

Tozaltı Özlü Kaynak Teli - Hardfacing Applications

Standards

EN 14700	T Fe3
TS EN 14700	T Fe3
DIN 8555	UP 6-GF-55-P

Properties and Applications

Flux cored wire for submerged arc hardfacing of parts subjected to low stress abrasion with high compression stress and high impact. SHF 604 flux is the proper flux for hardfacing applications. Due to it's high hardness weld metal is only machinable by grinding or carbide tipped tools.

Typical Applications : Hardfacing of steel mill rolls, crane wheels, cable sheaves.



Typical Chemical Values of Weld Metal

Type of Analysis	C	Si	Mn	Cr	Fe
Weld Deposit	0.30	0.90	0.95	3.80	94.05

Typical Mechanical Values of Weld Metal

Test Condition	Hardness (HRC)	Wear Index
As welded	55	58.8

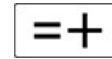
Application Information

Welding Positions



PA PB

Polarity:



Welding Parameters & Efficiency

Diameter (mm)
1.60
2.40

Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
38402GJAM2	1.60	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
38402GXAM2	1.60	25 kg	25.80	1	25.80	Wire Basket Spool (K435)
38402IXAM2	2.40	25 kg	25.80	1	25.80	Wire Basket Spool (K435)

Storage & Re-Drying Information

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