

## FCS 356

### Standards

EN 14700	T Fe 3
TS EN 14700	T Fe 3
DIN 8555	UP 6-GF-55-PT

### Properties and Applications

Flux cored wire for submerged arc welding, which is developed for hardfacing of parts subjected of impact high compressive stresses and metal-to-metal wear. Provides martensitic weld metal with high hardness. Weld metal can be machined by grinding or by diamond cutting bits. It is recommended to apply a buffer layer on base metals with high carbon and low weldability, before hardfacing. The deposit is heat treatable and forgeable.

**Typical Applications :** Suitable for hardfacing of rope and cable sheaves, bed knives, steel mill rollers, crane wheels, forging dies.

### Typical Chemical Values of Weld Metal

Type of Analysis	C	Si	Mn	Cr	Mo	W	Fe
Weld Deposit	0.45	0.40	1.25	5.80	1.60	1.60	88.90

### Typical Mechanical Values of Weld Metal

Test Condition	Hardness (HRc)
As welded	55

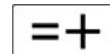
### Application Information

#### Welding Positions



PA PB

#### Polarity:



#### Welding Parameters & Efficiency

Diameter (mm)
2.40
2.80
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
38403IXAM2	2.40	25 kg	25.80	1	25.80	Wire Basket Spool (K435)
38403JXAM2	2.80	25 kg	25.80	1	25.80	Wire Basket Spool (K435)
38403LXAM2	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.