

FCO 250

Open-Arc Flux Cored Wire - Hardfacing Applications

Standards

EN 14700	T Fe9
TS EN 14700	T Fe9
DIN 8555	MF 7-GF-200-KPR

Properties and Applications

Open-arc flux cored wire for the rebuilding and reclamation of heavy parts, made of carbon steels or 14% Mn steels. Due to its high crack resistance, it is successfully used for buffer layer application prior to hardfacing on crack sensitive parts. Weld metal is very resistant to pressure and impact. Machinable with carbide tipped tools.

Typical Applications: Rebuilding and reclamation of railway rails and crossovers, mill shaft drive end, buffer layer on gyratory crusher mantles, re-pointing of shovel teeth, buffer layer on crawler tractor link prior to overlaying with more abrasion resistance and crack sensitive materials, rebuilding of rollers made of low alloy steels.



Dayanım Gösterdiği Aşınma Tipleri ve Mikroyapısı

Abrasion	■				
Adhesion	■	■	■	■	■
Darbe	■	■	■	■	■
Temperature	■	■	■	■	■
Corrosion	■	■	■	■	■

Typical Chemical Values of Weld Metal

Type of Analysis	C	Si	Mn	Cr	Fe
Weld Deposit	0.40	0.50	16.00	12.00	71.10

Typical Mechanical Values of Weld Metal

Test Condition	Hardness (HB)
As welded	200
After Cold Working	450

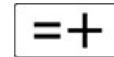
Application Information

Welding Positions



PA PB

Polarity:



Welding Parameters & Efficiency

Diameter (mm)
1.60
2.40
2.80

Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
38203GJAM2	1.60	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)

38203I2HM2	2.40	200 kg	215.00	1	215.00	Fiber Drum
38203IJAM2	2.40	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
38203IXAM2	2.40	25 kg	25.80	1	25.80	Wire Basket Spool (K435)
38203J2HM2	2.80	200 kg	215.00	1	215.00	Fiber Drum
38203JJAM2	2.80	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
38203JXAM2	2.80	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.