

FCH 325

Gas Shielded Flux Cored Welding Wire - Hardfacing Applications

Standards

EN 14700	T Fe 1
TS EN 14700	T Fe 1

Properties and Applications

Gas shielded flux cored wire, which is developed for hardfacing of parts, subjected to metal-to-metal friction wear (adhesion) and impact. The weld metal has medium hardness and machinable bu chip forming, hardening is possible by flame or by induction hardening. Due to high toughness and high crack resistance, it is also suitable for buffer layer applications. Interpass temperature should not exceed 250°C, during welding.

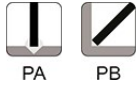
Typical Applications: Suitable for hardfacing rollers, railway rails and crossings, rolling mills, caterpillar track rolls and pads, gears, sprockets, shafts, crane rollers and mine car wheels.

Dayanım Gösterdiği Aşınma Tipleri ve Mikroyapısı

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

Application Information

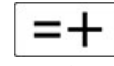
Welding Positions



PA

PB

Polarity:



Protection Gas:

M21 C1

Welding Parameters & Efficiency

Diameter (mm)
1.20
1.60

Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
38010EJAM2	1.20	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
38010GJAM2	1.60	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.