

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

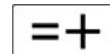
Application Information

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.