

## FCS 415

Tozaltı Özlü Kaynak Teli - Hardfacing Applications

### Standards

EN 14700	T Fe7
TS EN 14700	T Fe7
DIN 8555	UP 5-GF-40 (45)-C

### Properties and Applications

Flux cored wire for hardfacing of parts subjected to metal-to-metal wear (adhesion), moderate impact, creep, thermal fatigue and corrosion at high temperatures. Especially designed for hardfacing and renovation of continuous casting rollers. SHF 604 is the suitable flux for these hardfacing applications. Ferritic-martensitic weld metal contains Cr, Ni, Mo, V and Nb alloys. Provides smooth and easily machinable surface on stringer weld bead or weaving technique.

**Typical Applications:** Hardfacing of continuous casting rollers and similar rollers operating at high service temperatures.



### Typical Chemical Values of Weld Metal

Type of Analysis	C	Si	Mn	Cr	Ni	Mo	V	Nb	Fe
Weld Deposit	0.08	0.70	1.00	13.00	2.70	1.00	0.25	0.20	81.07

### Typical Mechanical Values of Weld Metal

Test Condition	Hardness (HRc)
As welded	42

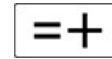
### Application Information

#### Welding Positions



PA PB

#### Polarity:



#### Welding Parameters & Efficiency

Diameter (mm)
2.40
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
38420I2GM2	2.40	250 kg	265.00	1	265.00	Fiber Drum
38420IXAM2	2.40	25 kg	25.80	1	25.80	Wire Basket Spool (K435)
38420L2HM2	3.20	250 kg	265.00	1	265.00	Fiber Drum
38420LXAM2	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.