FCH 355 S

Gas Shielded Flux Cored Welding Wire - Hardfacing Applications

Standards

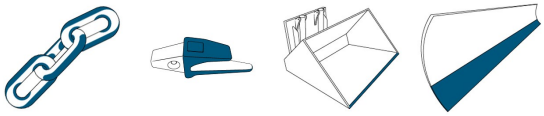
EN 14700	T Z Fe2
TS EN 14700	T Z Fe2
DIN 8555	MF 5-GF-40-P

Properties and Applications

Gas shielded, high alloyed, flux cored wire designed for hardfacing deposit with high hardness. Particularly suited for wearing parts subjected to metal to metal wear (adhesion) and high impact. Weld metal is tough, free of cracks and therefore resistant to shock and impacts. Weld metal deposit is only machinable by grinding or carbide tipped tools. If the base metal has high carbon and low weldability, a tough buffer layer with FCW 30 is recommended before hardfacing. Heat treatment after hardfacing will decrease as-welded hardness.

Typical Applications : Hardfacing of feeding screws, conveyors and machine parts in brick and mining industries.

Typical Applications



Typical Chemical Values of Weld Metal

Type of Analysis	C	Si	Mn	Cr	Fe
Weld Deposit	0.40	0.75	1.40	4.40	93.05

Typical Mechanical Values of Weld Metal

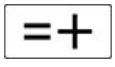
Test Condition	Protection Gas	Hardness (HRc)
As welded	C1	42

* Chemical compositon and mechanical properties are valid when using shielding gas EN ISO 14175 - C1 (%100 CO2) .

Application Information

Welding Positions

Polarity:



Protection Gas:

M21 C1

Welding Parameters & Efficiency

Diameter (mm)
1.20
1.60
2.40

Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
38002EJAM2	1.20	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
38002GJAM2	1.60	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
38002I2GM2	2.40	250 kg	365.00	1	365.00	Fiber Drum
38002IXAM2	2.40	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.