



**FC 25** DC+

**BUILD-UP**

**DESCRIPTION**

**Build-up wire with gas.** Low alloy build-up flux-cored wire with very good compressive strength and resistance to plastic deformation. An ideal base for subsequent overlay with a more wear resistant alloy. Also good when an easily machined "as-welded" deposit is required. **Deposits are fully machinable and can be flame cut.**

**TOTAL ALLOY CONTENT**

4,5 % (Carbon, Silicon, Manganese, Chromium, Molybdenum)

**TYPICAL APPLICATIONS**

Use on carbon and low alloy steels, rollers guides, slideways, etc.

**MECHANICAL PROPERTIES**

Hardness (as-welded): ~ 25 HRC  
 Deposit thickness: Unlimited

**WELDING PARAMETERS**

	Short-arc		Spray-arc			Pulsed spray arc welding					
	.045"	1/16"	.045"	1/16"		Use gas 98/2 Argon/Oxygen					
						.045"	1/16"				
Amps	90-200	150-220	250-325	300-375	Current	200	220	250	250	275	300
Volts	15-21	18-21	27-30	27-30	Peak Amps	350	375	425	350	375	400
Gas	Ar/CO <sub>2</sub>	Ar/CO <sub>2</sub>	Ar/O <sub>2</sub>	Ar/O <sub>2</sub>	Volts	24	25	26	24	25	26
CFH	25-30	25-30	40-45	40-45	CFH	40-45			40-45		
Stick-out	1/2"	3/4"	5/8"	3/4"	Stick-out	5/8"			3/4"		

When welding out-of-position, use the lower ranges of voltages and amperages: 16 - 19 volts and 100 - 150 amps.

Packaging: Spool of 11,4 kg

Other diameters available on request.

Electrodes also available: **Selectarc HB 25**

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*Specialized welding alloys and technology. For technical assistance or for ordering:*