



FC 40 DC+

BUILD-UP

DESCRIPTION

Build-up wire with gas and open arc. Medium hardness build-up flux-cored wire with excellent compressive strength. Recommended for applications where weld deposits must provide good metal-to-metal wear resistance, but still be machinable "as-welded". Deposits are machinable and can be flame cut. **Selectarc FC 40 in 1/16" (1.6 mm) diameter is open arc.**

TOTAL ALLOY CONTENT 6 % (Carbon, Silicon, Manganese, Chromium, Molybdenum)

TYPICAL APPLICATIONS

Use on carbon and low alloy steels. Because of its hardness and wear resistance, this wire is primarily intended as a build-up and final overlay for machine components, steel mill parts, undercarriage parts of earthmoving and mining equipment, gear teeth, key ways and carbon steel railroad track components.

MECHANICAL PROPERTIES

Hardness (as-welded): 39 - 42 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 ₂	Ar/CO ₂	Ar/O ₂	Ar/O ₂	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.

Coated electrodes also available: **Selectarc HB 40**

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