



FC 63Ti

HARD FACING

DESCRIPTION

Open-arc and slag-free hardfacing wire that provides a deposit containing finely dispersed titanium carbide particles in a high chromium martensitic tool steel matrix. **Selectarc FC 63Ti** is designed to provide excellent resistance to severe impact, gouging and grinding abrasion. Some shrinkage cracking is normal but can be minimized by proper preheating.

TYPICAL APPLICATIONS

For use on carbon steels, low alloy steels, manganese steels and cast irons. Augers, scraper blades, mixers, brick moulds, tampers, earthmoving equipment, crushing equipment, mining equipment, shovel buckets, mud pipes, mills.

TOTAL ALLOY CONTENT

18% (Carbon, Silicon, Manganese, Chromium, Titanium)

MECHANICAL PROPERTIES

Hardness (as-welded): 56 - 60 HRC
Deposit thickness: Maximum 3 passes

WELDING PARAMETERS

A shielding gas can be used with small diameters.

Diameter:	1/16" (1.6 mm)	.045" (1.2 mm)
Voltage:	24 – 35 V	22 – 32 V
Amperage:	150 – 350 A	125 – 300 A
Stick out:	1 - 2"	1 - 2"

Other diameters available on request.

Rév. : 21_08

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