

**FC 65**

DC+

**HARDFACING****DESCRIPTION**

**Open arc flux-cored hardfacing wire** with a high alloy content of elements which form chromium and niobium carbides. Therefore, especially used for hardfacing of parts subject to high abrasion, friction, heat at operation temperatures up to 450°C (842°F) and corrosion.

**TOTAL ALLOY CONTENT**

36 % (Carbon, Silicon, Manganese, Chromium, Niobium)

**TYPICAL APPLICATIONS**

Ash plows, coke crusher segments, screw conveyers, valves, exhaust fans, agitator fingers, mill guides, mixer paddles, rake teeth in furnaces, tong bits, slag ladles, elevator bucket tips etc.

**MECHANICAL PROPERTIES**

Hardness (3<sup>rd</sup> layer): 62 - 64 HRC  
Deposit thickness: 1 - 3 passes maximum

**WELDING PARAMETERS**

Diameter	7/64" (2.8 mm)	1/16" (1.6 mm)	.045" (1.2 mm)
Voltage	28 – 32 V	24 – 28 V	21 – 25 V
Amperage	250 – 450 A	150 – 350 A	100 – 300 A
Stick-out	1 - 2"	1 - 2"	1 - 2"

Coated electrodes also available: **Selectarc HB 65**

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