

HARDFACING

SELF-SHIELDED FLUX-CORED WIRES (FCAW)

A self-shielded cored wire which gives a Cr Mn alloyed weld metal for semi-automatic hardfacing.

Specifications

Classifications	EN 14700 : T Z Fe1
Approvals	DB : 82.039.09

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+
Alloy Type	Martensitic steel weld metal
Shielding Gas	None

Typical Weld Metal Analysis %

C	Mn	Si	Cr	Al
No shielding gas				
0.10	1.41	0.43	2.94	1.37

Deposition Data

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
1.6 mm	150-300 A	25-36 V	5.0-12.6 m/min	2.4-6.8 kg/h
2.4 mm	250-550 A	26-40 V	2.5-9.0 m/min	3.7-11.4 kg/h