

FCH 330

Gaz Korumalı Özlü Kaynak Teli - Hardfacing Applications

Standards

EN 14700	T Fe1
TS EN 14700	T Fe1
DIN 8555	MF 1 GF 300 P

Applications


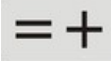
Gas shielded flux cored wire which is developed for hardfacing of parts subjected to metal-to-metal friction (ashesion) and medium degree impacts. Due to its very tough and crack resistant weld metal, it is also used for buffer layer applications. As the weld metal has medium degree hardness it can be machined by chip forming and flame or inductive hardening is possible. Interpass temperature should not exceed 250°C, during welding. Typical Applications : Hardfacing torque gears, gear wheels, shafts, pallet reels, crane wheels, pulleys, railway rails, crossings and switch points, rollers, caterpillar tracks, sprockets, track links, gears, shafts, pinion gears in sugar industry, screws in oil industry, crane drums and wheels, mine car wheels and sheaves.

Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Hardness (HB)
As welded	C1	275 - 325

* Kimyasal kompozisyon ve mekanik özellikler EN ISO 14175 - C1 (%100 CO2) koruyucu gazının kullanılması durumunda geçerlidir.

Application Information

Welding Positions 	Polarity: 				
Welding Parameters & Efficiency <table border="1"> <thead> <tr> <th>Diameter (mm)</th> </tr> </thead> <tbody> <tr> <td>1.20</td> </tr> <tr> <td>1.60</td> </tr> <tr> <td>2.40</td> </tr> </tbody> </table>	Diameter (mm)	1.20	1.60	2.40	Protection Gas: C1
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1.20					
1.60					
2.40					

Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (Kg)	Boxes per Outer Box	Outer Box Gross Weight (Kg)	Packaging Type
3802205M15	1.20	15 KG	15.70	1	15.70	Wire Basket Spool (K300MS)
3802208M15	1.60	15 KG	15.70	1	15.70	Wire Basket Spool (K300MS)
3802211M15	2.40	25 KG	25.80	1	25.80	Wire Basket Spool (K435)

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.