



**MANUFACTURERS OF A DIVERSE RANGE
OF ADVANCED WELDING CONSUMABLES**

**SECTION
11**

WI-0304 DS160A FC-43, Rev. 1, Date 02.01.2009

FC-43	SELF SHIELDING HARDFACING FLUX CORED WIRE				DATA SHEET NO. 160A				
					SPECIFICATION: DIN 8555				
CLASSIFICATION	MF1-400-GP								
PRODUCT DESCRIPTION	A self-shielded flux cored wire for heavy build-up and as a basis for harder finishing layer. The deposit contains small percentages of carbon, chromium, silicon, and manganese, which results a crack-free wear resistance deposit with a hardness about 43 HRC, dependent upon parent material dilutions and number of layer. It is particularly suitable for conditions of moderate abrasion and friction, coupled with resistance to heavy impact.								
WELDING FEATURES OF THE ELECTRODE	The formulation of the wire is such that it eliminates the need for external shielding gas.								
APPLICATIONS AND MATERIALS TO BE WELDED	Designed for the repair and rebuilding of mild steel and low-alloy ferritic steel components in either the cast or wrought condition. Specific applications include clutch plates, rope winches, trackwheels, rails, couplings, caterpillar tracks, and similar.								
WELD METAL ANALYSIS COMPOSITION % BY Wt.	C	Mn	Si	S	P	Ni	Cr	Fe	
	TYPICAL	0.3	2.6	0.9	0.015	0.012	0.02	2.8	Bal.
PHYSICAL PROPERTIES	Hardness			HRC		Other Properties			
	4 layers			42 ~ 44					
WELDING AMPERAGE DC+	Ø (mm)	2.4	2.8	3.2					
	MIN	200	250	350					
	MAX	300	400	450					
OTHER DATA	Wires that have become damp should be re-dried at 120°C for 1 hour.								
RELATED PRODUCTS	Please contact our Technical Department for details.								