

## COR®FACE 92 FC

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### DESCRIPTION

COR™FACE 92 FC is a flux-cored, self-shielded, hardfacing alloy designed to resist severe abrasion. This iron base alloy's abrasion resistance is attributable to its optimum microstructure, which hosts primary chromium carbides in an austenite-carbide eutectic matrix.

### APPLICATIONS

92 FC is typically used on moderate impact and severe abrasion resistance applications such as coal crusher rolls, cement mill pulverizer rings, and bucket teeth.

### PROCEDURE

Hardfacing generally does not require any heat treatment. Preheat and post heat according to the base material where necessary. The weld deposit will cross check.

### WELDING PARAMETERS

	Size	Volts	Amps	Stickout
FC-O	.035"	19-21	50-100	1/2"
FC-O	.045"	22-24	120-200	1"
FC-O	1/16"	24-26	200-300	1.25"
FC-O	3/32"	27-29	300-450	1.5"
FC-O	7/64"	27-29	350-500	1.5"
FC-O	1/8"	28-30	400-500	1.5"

Optional shielding gases such as CO<sub>2</sub> or Ar- CO<sub>2</sub> may be used. When a shielding gas is used reduce the Stickout to 1/2" to 3/4" and the voltage range can be from 18-30.

### MECHANICAL PROPERTIES

Hardness:           50-55 Rc 1 pass  
                          55-60 Rc 2+ passes

### CLASSIFICATION

Chromium Carbide Iron base hardfacing alloy.