

COR™FACE 9235 FC

DESCRIPTION

COR™FACE 9235 FC is a flux-cored, economical hardfacing alloy designed to resist abrasion. The gas-shielded versions of this wire can be welded out of position.

APPLICATIONS

9235 FC is typically used to overlay carbon and low alloy steels, manganese steels, and stainless steels. The welded deposit weathers severe abrasion, moderate impact, and metal-to-metal wear. Specific uses include dredge parts, earth moving equipment, and farm equipment.

PROCEDURE

Hardfacing generally does not require any heat treatment. Preheat and post heat according to the base material where necessary.

WELDING PARAMETERS

Size	Volts	Amps	Shielding Gas/Flux
MC-G .045"	19-21	175-225	75%Ar-25%CO ₂
MC-G 1/16"	20-23	225-275	75%Ar-25%CO ₂
FC-O .045"	21-23	160-200	1" stickout
FC-O 1/16"	24-26	175-225	1.25" stickout

MECHANICAL PROPERTIES

Hardness: 52-56 Rc 1 pass
53-57 Rc 2 pass

CLASSIFICATION

Iron base hardfacing alloy