

COR™MAIN 3301 FC

DESCRIPTION

COR™MAIN 3301 FC is a flux-cored wire for welding of gray, ductile and malleable cast iron. This product is an economical substitution for the 45-55% Nickel alloys when a high integrity weld is required. The FC-O product operates without a shielding gas.

APPLICATIONS

COR™MAIN 3301 FC is used to join cast iron components, and for joining steel to cast iron. Typical applications include overlaying cast iron journals and rolls prior to hardfacing, patching ingot molds and castings.

PROCEDURE

Submerged arc welding on large cast iron rolls may require a preheat/interpass temperature of up to 550°F. Post heat at 900°F for 3 hours. A post heat at 1150°F will enhance machining of the fusion line. Smaller welds on thinner sections can be done without any preheat.

WELDING PARAMETERS

Size	Volts	Amps	Stickout	Shielding Gas (optional)
FC-O 1/16"	24-27	190-250	1.25"	75%Ar-25%CO ₂
FC-O 3/32"	24-28	250-350	1.5"	75%Ar-25%CO ₂
FC-O 1/8"	26-30	300-450	1.5"	75%Ar-25%CO ₂

For submerged arc welding specify FC-S, use with Lincoln 880 flux.

MECHANICAL PROPERTIES

Hardness: 175 BHN as welded
28 Rc work hardened

CLASSIFICATION

Iron base, 36%Ni alloy