

COR®FACE 9260 FC

DESCRIPTION

COR™FACE 9260 FC is a flux-cored, 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. This alloy is an increased carbon, reduced chrome version of COR™FACE 92.

APPLICATIONS

9260 FC is typically used on minimal impact and severe abrasion resistance applications such as earth moving, crushing, and grinding equipment. Specific uses include screw conveyors, scraper blades, fan blades, dredge pumps and impellers, and roasting mill plows.

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 every 3/8" to 3/4".

WELDING PARAMETERS

Size	Volts	Amps	Stickout
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"

Optional shielding gases such as CO₂ or Ar- CO₂ may be used. When a shielding gas is used reduce the Stickout to ½" to ¾" and the voltage range can be from 18-30.

MECHANICAL PROPERTIES

Hardness: 52-57 Rc 1 pass
58-61 Rc 2 passes
59-64 Rc 3+ passes

CLASSIFICATION

Chromium-Carbide Iron base hardfacing alloy