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## COR™FACE 9250 FC

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### DESCRIPTION

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COR™FACE 9250 FC is a flux-cored, general-purpose hardfacing alloy designed to resist abrasion. The gas-shielded versions of this wire can be welded out of position.

### APPLICATIONS

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9250 FC is typically used on moderate impact and abrasion resistance applications such as crusher rolls, hammer mills, and dredge pump shells. The weld deposit can usually be applied without cross checking.

### PROCEDURE

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

### WELDING PARAMETERS

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Size	Volts	Amps	Stickout
FC-O .045"	19-21	175-225	1"
FC-O 1/16"	20-23	225-275	1 1/4"
FC-O 3/32"	24-26	250-350	1 1/2"
FC-O 1/8"	24-26	300-400	1 1/2"

\*75%Ar-25%CO2 or CO2 shielding gas will permit out of position welding.

### MECHANICAL PROPERTIES

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Hardness: 50-54 Rc as welded

### CLASSIFICATION

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Iron base hardfacing alloy, Medium Carbon, Medium Chrome.