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COR™FACE 9264 FC

DESCRIPTION

COR™FACE 9264 FC is a metal-cored, hardfacing alloy designed to resist severe abrasion. This iron base alloy's abrasion resistance is attributable to its optimum microstructure, which hosts' chromium carbides, boron carbides and titanium carbides in a martensitic matrix. The wire can be used with or without a shielding gas. The weld beads crosscheck to relieve stress similar to other high carbon high chrome alloys.

APPLICATIONS

9264 FC is typically used in severe abrasion combined with mild impact applications such as earth moving, crushing, drilling and grinding equipment.

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". Two layers is sufficient for most applications. If more than two layers are needed the base should be built up with COR™FACE 9250.

WELDING PARAMETERS

	Size	Volts	Amps	Stickout
FC-O	.045"	22-26	120-200	1"
FC-O	1/16"	22-26	200-300	1.25"

Optional shielding gases such as CO_2 or Ar- CO_2 may be used. When a shielding gas is used reduce the Stickout to ½" and the voltage range can be from 18-30.

MECHANICAL PROPERTIES

Hardness: 60-65 Rc

CLASSIFICATION

Chromium-Carbide, Boron-Carbide, Titanium-Carbide Iron base hardfacing alloy