

COR™FACE 95 FC

DESCRIPTION

COR™FACE 95 FC is a flux-cored, self-shielded, work hardening wire designed to resist impact. This high manganese wire could be classified as a “Hadfield” steel, and will rapidly work harden. This alloy is commonly referred to as a “Nickel-Chrome-Manganese”.

APPLICATIONS

95 FC is typically used as the overlay on manganese steel, carbon, and low alloy steels subjected to severe impact. Specific uses include: crusher rolls and cones, railroad frogs and crossings, bucket teeth, and impact hammers. It is also used as a buildup for abrasion resistant alloys such as COR-MET 9250 FC and 92 FC. Weld deposits can be flame cut.

PROCEDURE

No preheat required. Minimize heat input by quenching with water. Do not exceed 500 deg F interpass temperature.

WELDING PARAMETERS

Size	Volts	Amps	Stickout
FC-O .045"	24-26	120-180	1"
FC-O 1/16"	25-29	180-220	1.25"
FC-O 3/32"	26-30	270-330	1.5"
FC-O 1/8"	27-31	375-450	1.5"
FC-G .035"	15-17	75-125	75%Ar-25%CO ₂
FC-G .045"	21-23	140-180	75%Ar-25%CO ₂

MECHANICAL PROPERTIES

Hardness: 20 Rc as welded
 40+ Rc work hardened
 Tensile Strength: 120,000 psi

CLASSIFICATION

Iron base Mn-Ni-Cr steel