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COR™MAIN 33 FC

DESCRIPTION

COR™MAIN 33 FC is a flux-cored, iron-nickel wire formulated to weld gray, nodular and ductile cast iron.

APPLICATIONS

COR™MAIN 33 FC is used to join cast iron components, and for joining steel to cast iron. Typical applications include welding steel clips to cast iron wheels, overlaying cast iron rolls prior to hardfacing, patching ingot molds and castings, and welding coke oven doors.

PROCEDURE

No preheat or postheat is needed for most applications. Submerged arc welding may require a preheat/Interpass temperature of up to 550°F. Cool to room temperature. Post heat at 900°F for 3 hours. A post heat at 1150°F will enhance machining when extensive drilling or tapping is required.

WELDING PARAMETERS

Type	Size	Volts	Amps	Stickout
FC-O	.045"	23-26	150-190	1"
FC-O	1/16"	24-27	190-250	1 1/4"
FC-O	3/32"	24-28	250-350	1 1/2"
FC-O	1/8"	25-29	400-500	1 1/2"

* - For submerged arc welding use the FC-O wires and Lincoln 880 flux.

MECHANICAL PROPERTIES

Tensile:	85,000 psi
Yield:	45,000 psi
Elongation:	24%
Area Reduction:	22%
Hardness:	170 BHN

CLASSIFICATION

Iron base 33% Nickel alloy