

COR™ MAIN 97A FC

DESCRIPTION

COR-MAIN 97A FC is a flux-cored, hardfacing steel alloy designed to resist heat, impact, and hot abrasion. This alloy is available in submerged arc, and gas shielded wires.

APPLICATIONS

97A FC is widely used for repair and reclamation of steel mill components including blast furnace bells and hoppers, pinch, twist, and table rolls, and scale breakers. 97A can be multipassed without cracking, and machined to a fine finish.

PROCEDURE

Preheat and post heat according to the base material.

WELDING PARAMETERS

Type	Size	Volts	Amps	Stickout
MC-G	.045"	18-22	150-200	0.5"
FC-G	1/16"	21-25	200-300	0.5"
FC-G	3/32"	26-29	300-400	0.75"

Submerged arc wires are available in 1/16"-5/32"; use a neutral flux.

MECHANICAL PROPERTIES

Hardness: 48-52 Rc

CLASSIFICATION

Cr-Ni-Mo Hardfacing Steel