

HARDCORE 650

SELF-SHIELDED FLUX CORED WIRE OF NOMINAL 650HV HARDNESS

PRODUCT DESCRIPTION

Self-shield flux cored wire for surfacing applications in the flat and HV positions. The tubular wire has a lime-fluorspar flux fill which eliminates the need for an external shielding gas. Metal recovery about 90% with respect to wire.

SPECIFICATIONS

BS EN 14700 T Fe2

ASME IX QUALIFICATION

QW432 F-No

CHEMICAL COMPOSITION (WELD METAL WT %)

	C	Mn	Si	Cr	Mo	Al
Typical	0.8	2	0.8	2.5	0.2	1.7

ALL-WELD MECHANICAL PROPERTIES

Typical all-weld metal hardness:

Vickers (HV)	600-700
Rockwell (HRC)	55-60
Brinell (HB)	620-680

Preheat and dilution will affect hardness in the first two layers but will have little effect in subsequent layers.

TYPICAL OPERATING PARAMETERS

No shielding gas is required.

Current: DC+ve ranges as below:

Diameter (mm)	Amp-Volt Range	stickout
1.2	150-250A, 20-26V	40-50mm
1.6	200-300A, 24-30V	40-50mm

PACKAGING DATA

Spools in cardboard carton: 13kg

Where possible, preferred storage conditions are 60% RH max, 18°C min.

FUME DATA

Fume composition (wt %)

Fe	Mn	Ni	Cr	Cu	F	OES (mg/m ³)
18	7	<0.5	1.5	<0.5	12	5