



AUTOCORE FC 16Mn

FCAW HARD FACING
High Impact Work
Hardenable



SELF SHIELDED FLUX CORED WIRE DEPOSITING WORK HARDENING TYPE
ALLOY FOR JOINING AND SURFACING

ALLOY BASIS :

C, Mn, Cr

KEY FEATURES :

- Self shielded flux cored wire
- Excellent arc characteristics
- Low spatter, easy slag removal
- Work hardening type alloy for joining and surfacing of Mn steels
- Not recommended for ferritic steels

WELDING POSITION :



DCEP

TYPICAL APPLICATIONS :

- Crusher jaws
- Buffer layer for impact arms
- Buffer layer on crusher hammers

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

PHYSICAL PROPERTIES :

Condition	Hardness, HRc
As Welded	17-20
Work Hardened	40-42

Machinability



Abrasion Resistance



Impact Resistance



Corrosion Resistance



PARAMETERS - PACKING DATA :

Ø, mm	Voltage, V	Amperage, A	Kg/Spool
2.4	25 - 31	200-350	12.5
2.8	27 - 32	250-400	12.5

Physical Properties: With increase in number of squares, property improves