



FCAW Hard Facing
AUTOMIG FC 400

GAS SHIELDED FLUX CORED WIRE FOR RECLAMATION OF FORGING DIES



ALLOY BASIS :

C, Cr, Mn, Ni, Mo

KEY FEATURES :

- Gas shielded flux cored wire
- Low alloy steel weld deposit
- Stable and smooth arc
- Easy slag removal, smooth weld bead
- Excellent resistance to metal to metal wear and thermal shocks
- Suitable for multi-pass crack free welding
- Radiographic weld quality

WELDING POSITION :



DCEP

| Shielding Gas | Gas Flow Rate, LPM | Stickout, mm |
|------------------------|--------------------|--------------|
| 80Ar+20CO ₂ | 18-25 | 15-30 |

TYPICAL APPLICATIONS :

- For surfacing and reclamation of large hot working dies specially drop forging dies, hot working tools
- Suitable for H11, H13, DIN 1.2714 and DB-6 die block material

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

MECHANICAL PROPERTIES OF ALL WELD METAL :

| Condition | 3 Layer Hardness, HRc |
|-----------|-----------------------|
| As Welded | 38-44 |

PARAMETERS - PACKING DATA :

| Ø, mm | Voltage, V | Amperage, A | Kg/Spool |
|-------|------------|-------------|----------|
| 2.40 | 25 - 32 | 220 - 400 | 12.5 |