



PRODUCT DATA SHEET



ArcoCrush Fe 60 – SS (Self- shielded)

ArcoCrush™ is a family of alloys tailored to meet the aggressive applications of Australian Industries wear management

CLASSIFICATIONS	AS/NZS 2576-2005, 3460-B7 EN 14700 T Fe20 50 GR
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ArcoCrush FE 60 is a tubular cored hardfacing wire used for armouring & cladding as resistance to extreme abrasion in service applications up to 250°C. This alloy contains up to 60% Fused Tungsten Carbide (FTC), variations in wire size limit WC volume due to wire fill ratio of smaller diameter wires. The fine Tungsten carbide particles within the wire core remain solid during the welding process therefore requiring a minimal level of heat input to preserve integrity, a lower amperage setting also ensures the particles are evenly distributed throughout the Martensitic steel matrix of the weld bead. An indication of overheating is presented by dark surface.

The weld deposit is non machinable.

Applications

Low impact crushing components, mixing blades, Chutes, lips, edges or various types of mining process equipment for mobile or stationary applications, ground engaging tools, agricultural tools, earthmoving equipment, (bucket lips, rippers), brick industry components, pump impellers, augers, slurry pipework cladding, wearplate cladding.

Post weld Relief checking is normal. Best limited to two (2) layers maximum.

Gas shielding is not required (Self Shielded) , torch electrode positive polarity (DCEP)

Typical All- weld Metal Composition (Weight%)

C	other	WC	Fe
2.1	2.0	50- 60	Balance

Typical All- weld Metal Hardness range

60 HRc (2 layer)	Tungsten Carbide Particles
627 HB	2350 HV

PACKAGING

15kg, 25kg coils

Wire diameter Sizes

1.6mm,2.4mm 2.8mm