

GFC 20

FLUX CORED WIRE

CLASSIFICATION : JIS Z 3251 DF CrA

DESCRIPTION

Carbon and Chromium as major elements. Weld metal contains many different alloy elements such as Nb, V, Mo, W to get high hardness carbide structure. Wear resistance at elevated high temperature < 816°C. Good corrosion and oxidation resistance at elevated high temperature.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Mo	Cr	W	V	Nb
5.6	1.13	0.9	5.8	23.8	2	1.2	5.5

MECHANICAL PROPERTIES (RANGE)

As Welded HRC	Layers
63	2

TYPICAL APPLICATIONS

Suitable for hardfacing repair welding of blast spray nozzle and agitator blade.

PACKING PARAMETERS

Size (MM)	AMPS	Weight Of Spool (Kgs)
3.2	80-120	15 Kg
4	140-170	15 Kg
5	180-230	15 Kg

Note:

- 200-250°C x 1 hour baking prior to us.
- Max. 2 layer.
- Typical stress crack occurred to prevent peeling damage between base and weld metal.