

55FC-O

55FC-O is a self-shielded, flux-core wire that deposits a premium martensitic alloy steel of H-12 tool steel composition. It has excellent resistance to adhesive (metal-to-metal) wear. It also has good resistance to abrasion and impact, and maintains its hardness up to 1000°F. It is designed for use as an overlay on carbon and low alloy steels. Because of its high hardening ability, proper preheat may be required for crack-free deposits, particularly on low alloy steels. 55FC-O is formulated to optimize performance on small 110/220V type wire welding machines.

Typical Applications:

- Dredge parts
- Earth moving equipment
- Farm equipment

AWS Classification:

Hardfacing

Welding Current:

DCEN or DCEP

Typical wire chemistry (As Welded):

C: 0.4
Mn: 1
Si: 0.4
Cr: 5.8
Mo: 1.5
W: 1.4
Fe: BAL

Typical Mechanical Properties (As Welded on 1020 steel):

Hardness on 1 layer, Rc 47
Hardness on 2 layers, Rc 49
Hardness on 3 layers, Rc 53

Welding Positions:

All positions

Available Diameters:

.035", .045" & 1/16"

Operating Range in Amps:

.035": 80 - 120
.045": 120 - 150
1/16": 150 - 190