



TUNGCORE FCS

GENERAL CHARACTERISTICS:

ARCTEC® TUNGCORE FCS is a tungsten carbide metal cored welding wire that requires the use of a shielding gas. The deposit consists of fused tungsten carbide in a Ni-B-Si matrix. In addition to its abrasion resistance the deposit has a good resistance to heat and corrosion. Deposit is machinable by grinding only.

APPLICATIONS:

ARCTEC® TUNGCORE FCS is suited for hard facing on steel, alloy steel, stainless steel, and nickel alloy. As well as other applications that are subject to severe abrasion.

WELDING PROCEDURE:

Clean the weld zone of any grease, oil, rust, or any other contaminants by grinding. Avoid overheating and select the lowest amperage possible when welding.

WELDING PROCESS	MCAW
POLARITY	DC REVERSE
SHIELDING GAS AND FLOW RATE	98% Argon 2% Oxygen @ 30-40 CFH
HARDNESS	WFC >2300 HV
MATRIX	~47 HRC

DIAMETER	STICKOUT	AMPS	VOLTS
.045" (1.2MM)	¾" (19MM)	140-180	16-20

Helpful Hints on How To Use:

- Keep the stinger as straight as possible, no kinks!
- The shorter the stinger, the better since this is a nickel wire with Tungsten filler.
- Also, to help with feed of the wire, we recommend adding a "U" cog .045 feed wheel for the drive.
- Try not to over tighten the feed wheels.



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