



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
1/16" (1.60MM)	¾" (19MM)	160-180	18-20
3/32" (2.40MM)	1" (25MM)	200-240	21-23
7/64" (2.80MM)	1.25" (32MM)	220-270	21-23

SIZE	12" SPOOLS	COIL
.045" (1.2MM)	11 LB (15 kg)	
1/16" (1.6mm)	11 lb (15 kg)	
3/32" (2.40mm)		55 lb (25 kg)
7/64" (2.80mm)		55 lb (25 kg)



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