

FCW63B ®

Cored welding wire

The BMI FCW63B® hardfacing cored wire consists of a flux-core powder encased in a metallic sheath, designed for open-arc welding (without gas shielding or slag).

Its composition has been specifically engineered to provide high resistance to mineral abrasion, while also withstanding moderate impacts.

APPLICATIONS

Thanks to its high carbon (C) and chromium (Cr) content, the deposited metal, composed of chromium carbides, provides exceptional abrasion resistance. Hardfaced parts using BMI FCW63B® cored wire can offer wear resistance up to 50 times greater than conventional electrodes of the same hardness.

Suitable for multi-layer applications, BMI FCW63B® ensures homogeneous fusion, good metal spread, no slag formation, and a very smooth bead. The formation of cracks in the deposited metal is normal and does not affect service performance. The deposit can be machined by grinding or finishing.

This cored wire has been specifically developed for parts subjected to low to moderate impact while ensuring outstanding abrasion resistance.

Main applications : Design of high-performance composite parts, such as overlay plates, grinding and mineral conveying components, dredging pumps, mixers, and screen plates.

TYPICAL CHEMICAL COMPOSITION WELD METAL

C	Mn	Si	Cr	B
5	1.5	1.5	27	0.4

TYPICAL MECHANICAL PROPERTIES

Hardness 1st Layer	Hardness 2nd Layer
~ 60 HRC	~ 63-65 HRC

OPERATING CONDITIONS

Cored Wire Ø	1.2	1.6	2.4	2.8
Voltage (V)	22-32	24-35	26-35	28-35
Current (A)	140-250	150-350	250-450	250-450

PACKAGING

15kg Spools: Ø1.2, Ø1.6

25kg Coils: Ø2.4, Ø2.8

Available in Drums: Ø2.4, Ø2.8

Groupe BMI

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