

FCW30 Cr Mn ®

Cored welding wire

FCW30 Cr Mn is a **self-shielded flux-cored wire**, slag-free, based on **carbon, chromium, manganese, and silicon-rich alloys**. It is specifically formulated for **hardfacing applications** on parts exposed to **severe mineral abrasive wear** combined with **moderate impact**.

APPLICATIONS

The deposit is **very hard** and can only be **machined by grinding**. The hardfacing thickness should be limited to **2–3 layers** (8–10 mm). It can be used at temperatures up to **350°C**.

Main applications : Wear plates, grinding rollers, extraction or conveying screws, dredger teeth, mixer blades and liners, pump wheels, conveyor components.

TYPICAL CHEMICAL COMPOSITION WELD METAL

C	Si	Mn	Cr	B	Fe
5,0 – 6,5	2,0 – 3,0	2,0 – 3,2	29,0 – 32,0	2	+

TYPICAL MECHANICAL PROPERTIES

Hardness
60 ± 2 HRC

OPERATING CONDITIONS

Cored Wire Ø	1.2	1.6	2.4	2.8
Current (A)	110-200	160-280	200-280	260-320
Voltage (V)	18-24	20-27	22-28	24-28

CONDITIONS OF USE

Welding type: Self-shielded flux-cored wire (no shielding gas required)

Deposit limit: 2–3 layers or 8–10 mm thickness

Maximum service temperature: 350 °C

Shielding gas: Not required (self-shielded)

PACKAGING

15 Kg & 25 Kg Spools



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