S. R. Industries

STAR ARC 55FC-O

55FC-O *is a self-shielded, metal-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 hardenability, 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 - 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	*F,V,OH,H*
Available Diameters	*.035", .045" & 1/16"*

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Operating Range in Amps	
.035"	*80 - 120*
.045"	*120 - 150*
1/16"	*150 - 190*

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