

ARCTEC® FCS 2300



GENERAL CHARACTERISTICS:

ARCTEC® FCS 2300 is a composite flux cored welding wire for cast iron repair. The deposit provides an excellent match for the coefficient of expansion exhibited by cast irons. The light slag cover is easily removed enhancing visual weld inspection.

APPLICATIONS:

ARCTEC® FCS 2300 may be used for repair welds or for joining various types of cast irons. Cast iron may be welded to steel and other ferrous and non-ferrous material. The machinability of the weld material is similar to that of covered electrodes of similar composition.

WELDING PROCEDURES:

Clean weld zone free from oil, grease, rust and other contaminants. Preheat may not be required when welding thin sections, while preheat is recommended when welding heavy sections. In general, observe usual precautions regarding preheat, interpass temperature, joint preparation and welding technique as applies to the welding of cast irons.

MECHANICAL PROPERTIES:

Tensile Strength
73,000psi
500Mpa

Elongation
12% in 2"

Typical Hardness
Weld metal undiluted
190HB

OPERATING PARAMETERS:

WELDING PROCESS: FCAW

POLARITY: DC Reverse

SHIELDING GAS AND FLOW RATE:
Short-arc 98% Argon/2% O₂ at 35-45 CFH

Welding Parameters				
Wire Diameter	Shielding Gas	Stickout in/mm	Amps	Volts
.035" 1.2mm	98% Argon 2%O ₂	1/2"/13mm	150-180	26-28
.045" 1.2mm	98% Argon 2%O ₂	1/2"/13mm	220-250	27-29
1/16" 1.6mm	98% Argon 2%O ₂	5/8"/16mm	280-320	28-30

STANDARD SIZE AND PACKAGING:

Size	Packaging	
.035	12"spools	4.5 Kg
.045"	12"spools	15 Kg
1.2mm	12"spools	15 Kg

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