



# ARCTEC<sup>®</sup> FCS ECOFACE<sup>®</sup> AP

## GENERAL CHARACTERISTICS:

ARCTEC<sup>®</sup> FCS ECOFACE<sup>®</sup> AP is a seamless flux cored hardfacing wire. This product produces a deposit that provides excellent resistance to wear in applications where a combination of abrasive wear and compressive load prevails. The weld metal is machinable by grinding only. ARCTEC<sup>®</sup> FCS ECOFACE<sup>®</sup> AP operates on DC reverse polarity over a wide range of voltages and amperages.

## APPLICATIONS:

ARCTEC<sup>®</sup> FCS ECOFACE<sup>®</sup> AP is recommended for use in applications subjected to abrasion under compressive load.

## PROCEDURE:

Clean weld area free from oil, grease, rust, and other surface contaminants prior to starting the welding process.

## MECHANICAL PROPERTIES:

Layers  
1  
Typical Hardness  
57-62HRC

## CHEMICAL COMPOSITION:

This alloy is comprised of the following elements:

C      Mn      Si      Cr      Mo      Fe

## OPERATING PARAMETERS:

WELDING PROCESS: FCAW  
SHIELDING GAS AND FLOW RATE: 75% Argon/25% CO<sub>2</sub> at 30-35 CFH

POLARITY: DC Reverse

Operating Range		
Diameter	Amps	Volts
.045"	130-250	18-23
1/16"	150-300	21-27

## STANDARD SIZE AND PACKAGING:

Size	Packaging
.045" 1.2mm	12"spools 15.0 Kg
1/16" 1.6mm	12"spools 15.0 Kg

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