



# TUNG CORE FCS

## GENERAL CHARACTERISTICS:

ARCTEC® TUNG CORE FCS is a tungsten carbide metal cored welding wire that requires the use of a shielding gas. The deposit consists of fused tungsten carbide in a Ni-B-Si matrix. In addition to its abrasion resistance the deposit has a good resistance to heat and corrosion. Deposit is machinable by grinding only.

## APPLICATIONS:

ARCTEC® TUNG CORE FCS is suited for hard facing on steel, alloy steel, stainless steel, and nickel alloy. As well as other applications that are subject to severe abrasion.

## WELDING PROCEDURE:

Clean the weld zone of any grease, oil, rust, or any other contaminants by grinding. Avoid overheating and select the lowest amperage possible when welding.

<b>WELDING PROCESS</b>	MCAW
<b>POLARITY</b>	DC REVERSE
<b>SHIELDING GAS AND FLOW RATE</b>	98% Argon 2% Oxygen @ 30-40 CFH
<b>HARDNESS</b>	WFC >2300 HV
<b>MATRIX</b>	~47 HRC

DIAMETER	STICKOUT	AMPS	VOLTS
.045" (1.2MM)	3/4" (19MM)	140-180	16-20
1/16" (1.60MM)	3/4" (19MM)	160-180	18-20
3/32" (2.40MM)	1" (25MM)	200-240	21-23
7/64" (2.80MM)	1.25" (32MM)	220-270	21-23

SIZE	SPOOLS	COIL
.045" (1.2MM)	11lbs (5kg) & 33lbs (15kg)	
1/16" (1.6mm)	11lbs (5kg) & 33lbs (15kg)	
3/32" (2.40mm)		55lbs (25kg)
7/64" (2.80mm)		55lbs (25kg)



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