

FW3

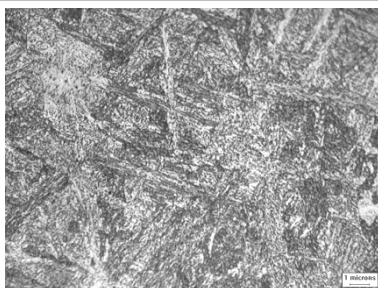
A gas-shielded flux-cored welding wire designed for the repair of forging plant including die dovetail repair. Suitable for rebuilding hot forging hammer die impressions susceptible to cracking or where machining capabilities are limited.

Nominal Composition

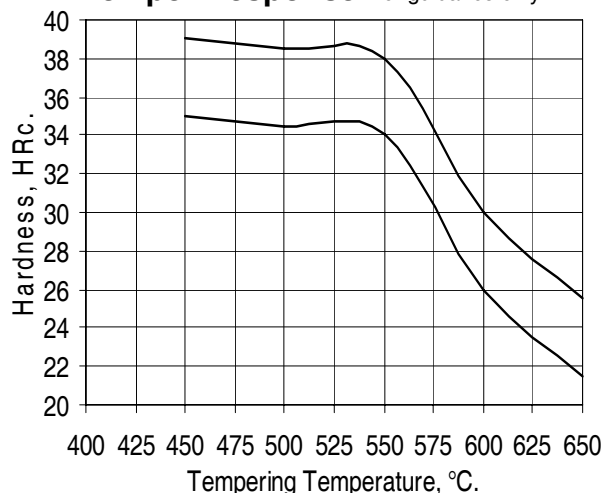
C	Mn	Si	Cr	Mo
0.1	1	1	2.5	1

Microstructure

Martensitic matrix with limited delta ferrite content.



Temper Response: for guidance only

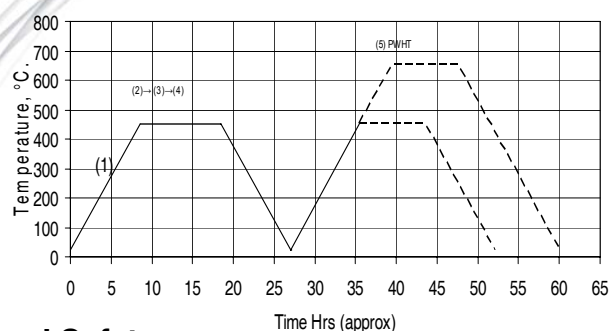


Welding Parameters: for guidance only

Ø, mm	Pre heat °C	Process	Polarity	Current (A)	Volts (V)	Stick Out, (mm)	Gas Type (L/min)
1.2	450	Manual	DCEP	160-240	26-30	35	Ar/20%CO ₂ M21 (15)
1.6	450	Manual	DCEP	200-350	28-30	35	Ar/20%CO ₂ M21 (15)
2.4	450	Manual	DCEP	240-450	29-32	35	Ar/20%CO ₂ M21 (15)
1.6	450	Forgeweld Machine	DCEP	200-450	28-36	35	Ar/20%CO ₂ M21 (25)
2.4	450	Forgeweld Machine	DCEP	350-650+	28-44	35	Ar/20%CO ₂ M21 (25)

Heat Treatment Guidelines

1	All heating and cooling rates	<50°C/hr
2	Preheat	450°C
3	Interpass temperature	450°C-650°C
4	Temperature equalisation after welding	450°C/2hrs
5	Post weld heat treat	~450-650°C/8hrs



Availability

1.2mm Ø	13Kg spool
1.6mm Ø	13kg spool
2.4 mm Ø	25kg coil. 250kg pay-off pack.

Health and Safety

Welding produces fumes and gases which can be dangerous to your health. Arc rays can injure eyes and burn skin. Electric shock can kill. It is important to take suitable precautions when welding and follow safe working practices. These should be based on the Welding Manufacturers Association leaflets 236, 237 and 239.

The information contained in this document is typical of the product described but is not guaranteed.
Specification may change without notice