

## Technocore Fe® 1.6 mm

### Metal cored composite wire

#### DESCRIPTION

Metal-cored wire made with spherical cast tungsten carbide (Spherotene®, hardness 3000HV) in an iron-based matrix for optimum abrasion resistance in severe environment conditions. The deposit offers a very good resistance to wear. Re-application of worn tool can also easily be done. The low heat input helps reducing tungsten carbide particles dissolution.

#### NORMALIZATION

DIN EN 14700: T Fe 20

#### CHEMICAL COMPOSITION

Element	C	Fe	W	Co	Mn
Content (wt%)	2.3 – 2.5	53.2 – 53.6	41.3 – 41.8	2.6 – 2.8	0.0 – 0.4

#### PROPERTIES

Hardness	Matrix	58 - 62 HRC
	Tungsten carbide	2800 - 3300 HV0.2
WC Particle Size Range	160 - 210 µm	
Coating density	11.6g/cm <sup>3</sup>	
Melting point	(matrix) 1100-1300 °C	
Standard layer thickness	3 mm	

#### WELDING RECOMMENDATIONS

Current (A) DC+ 125A  
 Voltage (V) 17.5V  
 Shielding Gas 82% Ar / 18% CO<sub>2</sub>  
 Wire Feed speed 3.5 m/min  
 Stick out 12-15 mm  
 Position



#### PACKING

15 Kg spools