**COR™FACE 9264 FC**

**DESCRIPTION**
COR™FACE 9264 FC is a metal-cored, hardfacing alloy designed to resist severe abrasion. This iron base alloy’s abrasion resistance is attributable to its optimum microstructure, which hosts’ chromium carbides, boron carbides and titanium carbides in a martensitic matrix. The wire can be used with or without a shielding gas. The weld beads crosscheck to relieve stress similar to other high carbon high chrome alloys.

**APPLICATIONS**
9264 FC is typically used in severe abrasion combined with mild impact applications such as earth moving, crushing, drilling and grinding equipment.

**PROCEDURE**
Hardfacing generally does not require any heat treatment. Preheat and post heat according to the base material where necessary. The weld deposit will cross check every 3/8” to 3/4”. Two layers is sufficient for most applications. If more than two layers are needed the base should be built up with COR™FACE 9250.

**WELDING PARAMETERS**

<table>
<thead>
<tr>
<th>Size</th>
<th>Volts</th>
<th>Amps</th>
<th>Stickout</th>
</tr>
</thead>
<tbody>
<tr>
<td>FC-O .045”</td>
<td>22-26</td>
<td>120-200</td>
<td>1”</td>
</tr>
<tr>
<td>FC-O 1/16”</td>
<td>22-26</td>
<td>200-300</td>
<td>1.25”</td>
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</tbody>
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Optional shielding gases such as CO₂ or Ar- CO₂ may be used. When a shielding gas is used reduce the Stickout to ½” and the voltage range can be from 18-30.

**MECHANICAL PROPERTIES**
Hardness: 60-65 Rc

**CLASSIFICATION**
Chromium-Carbide, Boron-Carbide, Titanium-Carbide Iron base hardfacing alloy