COR™FACE 9544 FC

DESCRIPTION
COR™FACE 9544 FC is a flux-cored, self-shielded, work hardening wire designed to resist impact and abrasion. This chrome-manganese wire could be classified as “Hadfield” steel, and will also withstand considerable heat input without embrittling.

APPLICATIONS
9544 FC is typically used for joining manganese steel to manganese, carbon, and low alloy steels. Specific uses include: crusher rolls and cones, railroad frogs and crossings, bucket teeth, and impact hammers.

PROCEDURE
Preheat according to base material. Do not exceed 600 deg F.

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&quot;</td>
<td>24-26</td>
<td>120-180</td>
<td>1&quot;</td>
</tr>
<tr>
<td>FC-O 1/16&quot;</td>
<td>25-29</td>
<td>180-220</td>
<td>1.25&quot;</td>
</tr>
<tr>
<td>FC-O 3/32&quot;</td>
<td>26-30</td>
<td>270-330</td>
<td>1.5&quot;</td>
</tr>
<tr>
<td>FC-O 1/8&quot;</td>
<td>27-31</td>
<td>375-450</td>
<td>1.5&quot;</td>
</tr>
</tbody>
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MECHANICAL PROPERTIES

Hardness: 20 Rc as welded
45+ Rc work hardened

Tensile Strength: 140,000 psi

Yield Strength: 90,000 psi

Elongation: 25%

CLASSIFICATION

Iron base Cr-Mn steel