



**SPECIALTY CORED WIRE
AND COATED ELECTRODES**

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COR™BALT 1 FC

DESCRIPTION

COR™BALT 1 FC is a flux-cored, cobalt base wear facing alloy designed for maximum abrasion, corrosion, and heat resistance. Tungsten, coupled with chromium carbides allows 1 FC to resist galling and oxidation, and to maintain an effective hardness at operating temperatures up to 1300°F. Deposits also have a low coefficient of friction, and consequently develop a high polish in service.

APPLICATIONS

Typical wearfacing uses include: cement plant machinery, steel plant equipment, metal working tools, coke pusher shoes, carbon scrapers, and rubber mixing equipment.

PROCEDURE

A minimum preheat of 350°F is recommended for mild steels. Preheat all other alloys according to the base material.

WELDING PARAMETERS

Size	Volts	Amps	Stickout	Shield Gas/Flux
MC-G .045"	16-30	120-250	1/2"	CO ₂ or Ar-CO ₂ mixtures
MC-G 1/16"	18-30	150-250	1/2"	CO ₂ or Ar-CO ₂ mixtures
FC-O 1/16"	24-28	200-300	1 1/4"	none
FC-O 3/32	24-28	250-350	1 1/2"	none
FC-S 3/32"	27-29	325-375	1"	Lincoln 880

MECHANICAL PROPERTIES

Hardness: 50-55 Rc as welded

CLASSIFICATION

AWS A5.21, ERCCoCr-C