

# OMEGA® - FLUX CORE

Flux Core Arc Welding  
(FCAW)

For hardfacing all ferrous metals requiring excellent abrasion resistance under impact.

## FEATURES

- Hardness 50-54 RC
- Carbide and austenite structure
- 88%-90% efficiency
- High deposition rate
- Shock resistant
- Excellent wear and abrasion resistance
- Excellent self-shielded running characteristics
- Magnetic

## CHARACTERISTICS

**OMEGA FLUX CORE** is a self-shielded general purpose hardfacing wire. Its exceptionally high chrome content provides resistance to the combined forces of abrasion and impact.

5

**OMEGA FLUX CORE** has great versatility and exhibits excellent running characteristics with a high bead contour and high deposition rate.

## APPLICATION

Proven applications include hardfacing crusher rolls and liners, breaker bars, bucket teeth, hammer mill hammers, pump impeller and liners.

APPROXIMATE SETTINGS: DCEP (reverse polarity)

WIRE DIAMETER	VOLTS	AMPS	STICK OUT
.045" (1.2mm)	15-26	100-250	3/4" - 1"
1/16" (1.6mm)	23-25	150-380	1" - 1 1/2"
7/64" (2.8mm)	26-30	200-400	1" - 1 1/2"

## SHIELDING GAS OPTIONS:

Not required. However, 100% CO<sub>2</sub> will enhance weld bead and lessen spatter.

