

# Orion Flux Core

## Flux Core Arc Welding (FCAW – Wire)

Hardfacing for extreme abrasion resistance on carbon steels, alloy steels, cast iron and manganese steels.

### Features

- Extreme Abrasion Resistance
- High Hardness, up to 60–65 RC
- Smooth Running
- Boron Carbide alloy, for excellent hardness and abrasion resistance
- Cuts easily with a torch
- Excellent for both industrial and agricultural application
- 90% efficiency
- Self Shielded (no gas required) works well with “suitcase” welders.

### Characteristics

**Orion Flux Core** is a self-shielded wire with excellent efficiency and running characteristics. It is ideal for extreme abrasion applications with light impact. Made of Boron carbides suspended in a martensitic matrix, this wire produces excellent hardness of 60 RC in one pass, and 65 RC in a second. **Orion Flux Core** has a 90% efficiency rate, producing very hard deposits quickly. It is exceptionally smooth running, getting the job done quickly with a high yield of material on the work piece. **Orion Flux Core** is a two-pass maximum wire and may stress crack due to high hardness.

Ideal for extreme abrasion applications in mining, quarrying, dirt and sand work, shafts, impellers, transport screws and loaders

### Technical

Size and Amps AC/DC ±20%

Inches	.045	1/16
(mm)	(1.2)	(1.6)
Volts	23–32	26–33
Amps	140–230	180–300
Stick Out	1/2" – 3/4"	3/4" – 1"

With DC use reverse polarity (DCEP)

### Shielding Gas Options

- No Gas Required

### Application

- Self-Shielded, Ideal for field work with a “suitcase” welder
- Single pass recommended, maximum two passes
- Ideal for farming and dirt working applications.

### Spool Size Options

- 10# Available in .045
- 25# Available in .045 and 1/16"