

**POWDER SELECTION TABLE FOR HOT METALLIZING (FUSETEC)
AND COLD METALLIZING (BONDTEC)**

PRODUCTS	F 920	F 940	F 960	F 968	B 91	B 92	B 93	B 94	B 95	B 96
PROPERTIES										
Hardness (HRC)	15 - 20	36 - 43	58 - 63	60 +WC	—	80 (HRB)	30 - 32	64 - 66 (HRB)	40 - 42 +WC	80 (HRB)
Type of flame	Slightly carburizing				Slightly carburizing (except B94 = oxidizing flame)					
Hot metallizing	✓	✓	✓	✓						
Cold metallizing					✓	✓	✓	✓	✓	✓
Machinable deposit	1	2				1	3	1		2
Grindable deposit	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
Underlaying	✓				✓					
Bronze								✓		
Non-ferrous metals					✓	✓	✓	✓	✓	✓
Ferrous metals	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
Build-up	1	2				2		1		3
Hardfacing			✓	✓			✓		✓	
Impact resistance	3	1	2							
Abrasion resistance			2	1			2		1	3
Heat resistance	3	3	1	2						
Corrosion resistance	1	1	1	1		2	2	2	2	1
Applications in food industry	1	1	1			2		3		1
Buffing		2	1				3	1	2	

1 = Most efficient product(s) ; ✓ = Recommended product(s)

Note :

This table is not exhaustive; other products may be suitable for certain applications and/or characteristics. Consult the **FSH Welding Canada** Technical Department.