



# FCO 6675G

*Self-shielded hardfacing wire  
For extreme abrasion*

## Classification

EN 14700 : T Z Fe8

## Description & Applications

Flux cored wire for self-shielded metal arc hardfacing of components subjected to extreme abrasion under high load and moderate impacts. High Chromium cast iron deposit with addition of tungsten, Niobium, Molybdenum and Boron.

High hardness reached directly on first layer that considerably reducing welding time. Could be used for application with service temperature up to 750°C.

Also applicable in 2 layers max.

**Main applications:** Excavator buckets, crusher, extrusion screws, shredders, hammers, fan blades, sinters...

## Typical Chemical Composition ( % )

	C	Si	Mn	Cr	Mo	W	Nb	B	P	S	Fe
Min											
Max					Not specified						Rem.
Type	1.1	0.8	0.8	22.0	3.5	6.0	3.5	+	0.015	0.010	Rem.

## All Weld Metal Mechanical Properties

Hardness (1<sup>st</sup> layer)  
66-68 HRC as welded

## Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.6	170 – 190	26 – 28	20 - 25	-

FT En-CM49-210507



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