



## FCO HB60

*Self-shielded hardfacing  
Tubular flux cored wire  
For abrasion and impact*

### Classification

EN 14700 : T Fe8

### Description & Applications

Tubular flux cored wire for self-shielded metal arc hardfacing of components subjected to abrasion and impacts in wet or dry environment. Hardfacing in 2 or 3 layers. Mainly use for welding in flat position but could be used in semi upward or semi downward position.

**Main applications:** Bucket teeth, lips and undersides, cutting edges, steel mill rolls, cable drums, sand dredge equipment, dragline buckets, conveyor chutes.

### Typical Chemical Composition ( % )

|      | C    | Si  | Mn  | Cr  | Mo   | W    | V    | Nb   | P     | S     | Fe   |
|------|------|-----|-----|-----|------|------|------|------|-------|-------|------|
| Min  | 0.2  |     |     | 5   |      |      |      |      |       |       |      |
| Max  | 2    |     | 3   | 20  | 5    | 2    | 2    | 10   |       |       | Rem. |
| Type | 0.50 | 2.5 | 1.5 | 8.5 | 0.01 | 0.01 | 0.01 | 0.01 | 0.015 | 0.010 | Rem. |

### All Weld Metal Mechanical Properties

Hardness (3<sup>rd</sup> layer)  
56 - 59 HRC as welded

### Welding Current & Instructions

| Welding mode | Wire Ø<br>(mm) | Welding parameters |             |                | Shielding Gas |
|--------------|----------------|--------------------|-------------|----------------|---------------|
|              |                | Current (A)        | Voltage (V) | Stick out (mm) |               |
| FCAW<br>= +  | 1.2            | 100 - 300          | 21 - 35     | 12 - 25        | -             |
|              | 1.6            | 150 - 300          | 24 - 35     | 15 - 25        |               |
|              | 2.0            | 200 - 400          | 26 - 35     | 20 - 50        |               |
|              | 2.4            | 250 - 450          | 26 - 35     | 25 - 50        |               |
|              | 2.8            | 250 - 450          | 28 - 35     | 25 - 50        |               |

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