



FCW 60

Hardfacing metal cored wire

Classification

EN 14700 : T Fe6

Description & Applications

Flux cored wire for gas shielded (Ar + CO₂) arc hardfacing without slag of carbon or low alloyed steels for an optimal balance between abrasion, friction and impact resistance. Could be used to service temperature up to +300°C.

Main applications: Dies transporter, cams, gear teeth...

Typical Chemical Composition (%)

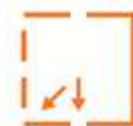
	C	Si	Mn	Cr	Mo	Nb	P	S	Fe
Min									
Max	2.5		3	10	3	10			Rem.
Type	0.70	0.60	1.4	6.0	0.50	0.01	0.015	0.010	Rem.

All Weld Metal Mechanical Properties

Hardness (3rd layer)
57-62 HRC as welded

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	100 - 280	23 - 33	10 - 25	ISO 14175 : M21 (Ar/CO ₂) 10 - 20 l/min
	1.6	150 - 400	23 - 35	10 - 25	



FT En-CM04-200907

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