



# FCW 60G

*Hardfacing flux cored wire  
Without slag*

## Classification

EN 14700 : T Fe2

## Description & Applications

Flux cored wire for gas shielded (Ar + CO<sub>2</sub>) 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 ( % )

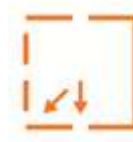
	C	Si	Mn	Cr	Ni	Mo	W	Co	V	P	S	Fe
Min	0.4											
Max	1.5		3	7	1	1	1	1	1			Rem.
Type	0.50	0.60	1.2	5.7	0.01	0.80	0.01	0.01	0.01	0.015	0.010	Rem.

## All Weld Metal Mechanical Properties

Hardness (3<sup>rd</sup> layer)  
~59 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 - 300	24 - 32	12 - 25	ISO 14175 : M21 (Ar/CO <sub>2</sub> ) 10 - 20 l/min
	1.6	150 - 300	24 - 32	12 - 25	



FT En-CM05-190729

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