



MIG FICO188

Classification

AMS : 5801
EN 3888 : CoCr22Ni22W15

AFNOR : KcN22W

Description & Applications

Cobalt base solid wire for GMAW harfacing of Cobalt alloy with similar chemical composition like alloy 188, UNS R30188, AMS 5608, Matériau 2.4683, CoCr22NiW. Creep resistant and oxidation resistant up to 1150°C. Good behaviour to important thermal and mechanical shocks.

Main applications: Aeronautical industry.

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Fe	W	La	P	S	B	Co
Min	0.05	0.20		20.00	20.00		13.00	0.02				
Max	0.15	0.50	1.25	24.00	24.00	3.00	16.00	0.12	0.020	0.015	0.015	Rem.
Type	0.10	0.30	0.80	22.0	23.0	2.0	14.0	0.05	0.006	0.002	0.003	Rem.

All Weld Metal Mechanical Properties

Hardness (as welded)

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Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	(V)	
MIG = +	1.2 1.6	140-180 160-200	22-27 24-28	ISO 14175: I1(Ar) / M11 (Ar/CO ₂) 18 L/min

Preheat large components or special steels to 200-400°C. Keep this temperature during welding and cool down slowly, preferable in an oven, to reduce the risk of cracking while cooling.

FT En-MC03-200309

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