



MIG FICO31

Classification

AMS : 5789
EN 4327 : CoCr26Ni11W8

AFNOR : KC25NW

Description & Applications

Cobalt base solid wire for GMAW harfacing of Cobalt Grade 31* and alloy with similar chemical composition. Creep resistant and oxidation resistant up to 1150°C. Good behaviour to important thermal and mechanical shocks.

Main applications: Aeronautical industry.

* Trademark Kennametal

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Fe	W	P	S	Co
Min	0.45			24.50	9.50		7.00			
Max	0.55	1.00	1.00	26.50	11.50	2.00	8.00	0.040	0.040	Rem.
Type	0.50	0.80	0.80	25.5	10.5	1.0	7.5	0.010	0.005	Rem.

All Weld Metal Mechanical Properties

Hardness (as welded)
~ 30 HRC

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-MC02-200309

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