



MIG FICO414

Specification

GE B50 A 823

AFNOR : KC29NW

Description & Applications

Cobalt base solid wire for GMAW hardfacing of jet engine or turbine parts. Excellent resistance to corrosion and high temperature.

Main applications: Aeronautical industry.

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Fe	W
Min	0.10	0.50	0.40	28.5	9.5		6.5
Max	0.15	1.00	1.00	30.5	11.5	1.00	7.6
Type	0.12	0.80	0.90	29.0	10.2	0.1	7.0

	Cu	Zr	P	S	B	Co
Min						
Max	0.15	0.02	0.01	0.008	0.003	Rem.
Type	0.01	0.005	0.005	0.002	0.002	Rem.

All Weld Metal Mechanical Properties

Hardness (as welded)

-

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

FT En-MC05-200309

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.

www.fsh-welding.com - info@fsh-welding.fr