



MIG FICO694

Classification

EN 4326 : CoCr28W20Ni5V1
GE B50TF55

AFNOR : KC28WN

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	Mo	Fe
Min	0.70			26.00	4.00		
Max	1.00	1.00	1.00	30.00	6.00	0.50	3.00
Type	0.085	0.60	0.30	28.0	5.8	0.08	2.4

	W	V	P	S	B	Co	W+Mo
Min	18.00	0.75			0.005		
Max	21.00	1.25	-	-	0.100	Rem.	21.0
Type	20.0	1.0	<0.01	<0.01	0.03	Rem.	<21.0

All Weld Metal Mechanical Properties

Hardness (as welded)
47-54 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

FT En-MC06-200309

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