



MIG FICOT800

Specification

GE B50TF193

Description & Applications

Cobalt base solid wire for GMAW hardfacing of jet engine or turbine parts. Weld metal deposit characterised by low coefficient of friction.

Main applications: Aeronautical industry.

Typical Chemical Composition (%)

	C	Si	Cr	Ni	Mo	Fe
Min		3.00	16.50		27.00	
Max	0.08	3.80	18.50		30.00	
Type	0.01	3.5	18.0	1.0	29.0	1.0

	P	S	N	O	Co	Ni+Mo
Min						
Max	0.03	0.03	0.07	0.05	Rem.	3.00
Type	0.01	0.01	0.01	0.01	Rem.	<3.00

All Weld Metal Mechanical Properties

Hardness (as welded)

55-60 HRC

Welding Current & Instructions

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

FT En-MC08-200309

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