



## TIG FICO694

### Classification

EN 4326 : CoCr28W20Ni5V1  
GE B50TF55

AFNOR : KC28WN

### Description & Applications

Cobalt base solid rod for TIG 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	Shielding Gas
TIG = -	ISO 14175 : I1 (Ar) 6-12 L/min

FT En-TC06-170717

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