



FCW 60NB

Hardfacing metal cored wire against abrasion

Classification

EN 14700 : T Fe6

Description & Applications

Flux cored wire for gas shielded (Ar + CO₂) arc hardfacing without slag of parts subjected to impact and abrasion under high stresses. Weld metal deposit composed with a martensitic structure with finely dispersed niobium carbide particles. crack-free weld metal which may be machined despite its high hardness. Also suitable for multi-layer hardfacing.

Main applications: Crushing hammers and rollers, leading edges and teeth of excavator buckets, bulldozer and scraper blades, rotary crusher cones, dipper teeth ...

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Mo	Nb	Ni	P	S	Fe
Min										
Max	2.5		3	10	3	10				Rem.
Type	1.5	0.8	0.8	6.5	0.01	6.0	0.6	0.015	0.010	Rem.

All Weld Metal Mechanical Properties

Hardness (3rd layer)
~54 HRC as welded

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.6	130 - 350	16 - 32	12 - 25	ISO 14175 : M21 - M20 – M12 (Ar/CO ₂) 10 - 20 l/min



FT En-CM49-260609

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