



FCW 60G

*Hardfacing flux cored wire
Without slag*

Classification

EN 14700 : T Fe2

DIN 8555 : MSG 6-GF-55-GSP

Description & Applications

Flux cored wire for gas shielded (Ar + CO₂) arc hardfacing without slag of carbon or low alloyed steels for an optimal balance between abrasion, friction and impact resistance. Could be used to service temperature up to +300°C.

Main applications: Dies transporter, cams, gear teeth...

Typical Chemical Composition (%)

C	Si	Mn	Cr	Mo	P	S	Fe
0.50	0.70	1.2	6.0	0.70	0.015	0.010	Rem.

All Weld Metal Mechanical Properties

Hardness (3rd layer)
~ 55 HRC as welded

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	100 - 300	24 - 32	12 - 25	ISO 14175 : M21 (Ar/CO ₂) 10 - 20 l/min
	1.6	150 - 300	24 - 32	12 - 25	

FT En-CM05-160211



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