



# FCW 60

*Hardfacing metal cored wire*

## Classification

EN 14700 : T Fe6

DIN 8555 : MSG 6-GF-60-GP

## Description & Applications

Flux cored wire for gas shielded (Ar + CO<sub>2</sub>) 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	1.5	5.5	0.60	0.015	0.010	Rem.

## All Weld Metal Mechanical Properties

Hardness ( 3<sup>rd</sup> 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 - 280	23 - 33	10 - 25	ISO 14175 : M21 (Ar/CO <sub>2</sub> ) 10 - 20 l/min
	1.6	150 - 400	23 - 35	10 - 25	



FT En-CM04-160211

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[www.fsh-welding.com](http://www.fsh-welding.com) - [info@fsh-welding.fr](mailto:info@fsh-welding.fr)