



AUTOMIG FC 580

FCAW HARD FACING Abrasion-Impact

ALLOY BASIS :

C, Cr

KEY FEATURES:

- Basic type flux cored wire
- Smooth arc characteristics
- Low spatter, low fumes
- Non-machinable air hardenable deposit
- Resist high stress abrasion and friction
- Can withstand impact load of medium severity
- Resistant to spalling and cracking


TYPICAL APPLICATIONS:

- Hard facing applications on carbon steel and manganese components
- Machine parts subjected to high frictional wear
- Repair on damaged cold cutting tools
- Surfacing on austenitic manganese steels
- Screw conveyers, concrete mixer blades, crusher jaws and cones
- Pug mill screws, coal chutes dipper teeth, bucket teeth, crusher plates
- Brick machinery, pellet plant and tamping tools




MECHANICAL PROPERTIES OF ALL WELD METAL:

Condition	Hardness, 3 Layer HRc (BHN) , Typical
As Welded	55 (570)

PARAMETERS - PACKING DATA:

Ø , mm	Kg/Spool	
1.2	15	 DCEP STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box
1.6	15	

Shielding Gas	Gas Flow Rate, LPM
CO ₂	15-20

Machinability	Metal to Metal WearResistance	Impact Resistance	Corrosion Resistance
			

Physical Properties: With increase in number of squares, property improves