



# AUTOMIG FC 600

FCAW HARD FACING Abrasion-Impact

### ALLOY BASIS :

C, Cr, Mo

### KEY FEATURES:

- C, Cr, Mo alloyed flux cored wire
- Smooth arc characteristics
- Low spatter, Minimal slag
- Air hardenable deposit
- Non machinable weld can be finished by grinding
- High hardness in single layer
- Can withstand mild impact


### TYPICAL APPLICATIONS:

- Drilling bits, Punches, Dies
- Crane wheels, Shear blades
- Crushers, Hammers
- Paper cutting knives, Mine rails
- Oil expeller worms
- Conveyor parts




### MECHANICAL PROPERTIES OF ALL WELD METAL:

| Condition | Hardness, 1 Layer HRc (BHN) , Typical |
|-----------|---------------------------------------|
| As Welded | 58 (600)                              |

### PARAMETERS - PACKING DATA:

| Ø , mm | Kg/Spool |   |
|--------|----------|---|
| 1.2    | 15       |  DCEP<br><b>STORAGE / HANDLING :</b><br>Keep dry and follow handling instructions mentioned on the box |
| 1.6    | 15       |   |

| Shielding Gas                                  | Gas Flow Rate, LPM |
|--|--------------------|
| 80Ar+20CO <sub>2</sub> or 100% CO <sub>2</sub> | 15-25              |

| Machinability | Metal to Metal WearResistance   | Impact Resistance   | Corrosion Resistance  |
|---------------|---|---|---|
|               |  |  |  |

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