



**FCAW HARD FACING Abrasion-Impact**  
**AUTOMIG FC 580**

FLUX CORED WIRE FOR RESISTANCE AGAINST HIGH ABRASION AND MODERATE IMPACT



**ALLOY BASIS :**

Medium Carbon High Chromium

**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

**WELDING POSITION :**



DCEP

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
CO <sub>2</sub>	10-15	10-20

**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

**STORAGE / HANDLING :**

Keep dry and follow handling instructions mentioned on the box

**PHYSICAL PROPERTIES :**

Condition	Hardness, 3 Layer HRc (BHN)
As Welded	54-57 (550-600)

**Machinability**

**Abrasion Resistance**

**Impact Resistance**

**Corrosion Resistance**

-



**PARAMETERS - PACKING DATA :**

Ø x L, mm	Voltage, V	Amperage, A	Kg/Spool
1.2	23 - 31	120-250	15
1.6	25 - 33	200 - 380	15

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