



**FCAW HARD FACING Abrasion**  
**AUTOMIG FC 600**

FLUX CORED WIRE FOR HIGH ABRASION RESISTANCE



**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

**WELDING POSITION :**



**DCEP**

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
80Ar+20CO <sub>2</sub> or 100% CO <sub>2</sub>	12-25	10-20

**TYPICAL APPLICATIONS :**

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

**STORAGE / HANDLING :**

Keep dry and follow handling instructions mentioned on the box

**PHYSICAL PROPERTIES :**

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

**Machinability**

**Abrasion Resistance**

**Impact Resistance**

**Corrosion Resistance**

-



**PARAMETERS - PACKING DATA :**

Ø x L, mm	Voltage, V	Amperage, A	Kg/Spool
1.2	22 - 32	120 - 300	15
1.6	24 - 34	160 - 350	15

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