

# GFC 600HB

## HARD FACING FLUX CORED WIRE

### IDENTIFICATION

GFC 600HB

### DESCRIPTION

Flux cored wire for hardfacing application by GMAW process. Deposited weld metals has high resistance against corrosion, abrasion and impact deformation. The wire is universal and finds many applications in the industries.

### WELD METAL ANALYSIS (RANGE) %

| C        | Mn       | Si       | Cr      | Mo       |
|----------|----------|----------|---------|----------|
| 0.40 max | 0.48 max | 2.95 max | 7.4 max | 0.40 max |

### MECHANICAL PROPERTIES (RANGE)

| Hardness        |
|-----------------|
| 600 HRC approx. |

### TYPICAL APPLICATIONS

Quarries, Mines, Steel works, Cement works, Crushing plants, Wood industries, Tile industries, Agriculture machinery, Transport rolles, Sand Pumps.

### MICROSTRUCTURE

Microstructure of the weld metal : Ferrite and martensitic.

### PACKING PARAMETERS

| Wire Dia (mm) | Welding Parameters       |             | Shielding Gas                   | Weight / Spool (kg) |
|---------------|--------------------------|-------------|---------------------------------|---------------------|
|               | Current DC (+)<br>(Amps) | Voltage (V) |                                 |                     |
| 1.2           | 150 - 300                | 23 - 29     | 80% Ar + 20% CO2<br>OR 100% CO2 | 15                  |