

AA GGG

CATEGORY FCAW Flux-Cored

TYPE Medium-alloy high-basidity flux-cored wire with slag for hardfacing using Ar-CO2 mix

APPLICATIONS Build-up of cast iron and alloyed grey-cast iron Well suited for warm and in special applications for cold welding. Used to fill-in voids and pores, build-up of worn-down parts.

PROPERTIES Very good welding and wetting characteristics and high resistance to cracks and fissures. Extreme good deposition rate compare to MMA.
High strength and good bonding weld metal..

CLASSIFICATION EN ISO 1071:
DIN 8555: MSG Fe-2

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APPROVALS CE approved

WELDING POSITIONS:



C	Mn	Si	Cr	Mo	V	Fe
0.06	0.6	0.4	0.6	0.1	6	bal

MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	-	-	-				100-250

AW: as welded

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Packing		
	Voltage (V)	Current (A)	Spools	kg/spool	kg/pallet
1.2	20-26	180-250	K-300	16	1024
1.6	22-26	180-350	K-300	16	1024

REDRYING TEMPERATURE Not required