

AUTOMIG FC 560

Flux Type

Basic

Characteristics:

Low alloy basic folded flux-cored wire for hardfacing applications. Weld deposits are non-machineable. Weld deposit is tough, crack resistant and highly resistant to abrasion and wear. It is moderately resistant to impact loading.

Typical Applications:

Hardfacing excavator pits, excavator bucket, cutting edges, grab teeth, conveyor worm drives, percussion and drilling bits, crusher jaws and cones, crane-wheels, dipper teeth, cane cutting knives, etc. Before depositing on hardenable steels, a buffer layer of Automig FC- 71T5 is recommended.

Shielding Gas: CO₂

10-15 litres/min

Current Condition: DC (+)

Weld Metal Chemistry, wt %

C	Cr	Si	Mn	Mo
0.40-0.65	4.50 -6.50	0.35-0.75	1.30-1.90	0.40-0.80

All Weld metal hardness, BHN - 450-500 (After 3 layers in as welded condition)

Chemical & mechanical properties given above are with A 5.32 SG-C gas (100% CO₂)

The chemistry and mechanical properties of the weld metal will vary with the type of shielding gas.

Welding Positions

Flat & Horizontal

Packing Data

Dia., mm	1.2	1.6
Plastic Spools, net wt Kg	15	15



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