

# AUTOMIG FC 580

**Classification: -**

## 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, Concrete mixer blades, scraper blades, cement die rings, dipper, etc.

Shielding Gas: CO <sub>2</sub>	10-15 litres/min	Current Condition: DC (+)		
Weld Metal Chemistry, wt %				
C	Mn	Si	Cr	Mo
0.40-0.65	1.30 - 1.90	0.35-0.75	5.00-6.50	0.35-0.85

All Weld metal hardness, BHN - 550-600 (After 3 layers in as welded condition)

Chemical & mechanical properties given above are with A 5.32 SG-C gas (100% CO<sub>2</sub>)

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

Welding Positions	Flat & Horizontal	
Packing Specifications		
Dia., mm	1.2	1.6
Plastic Spools, net wt Kg	15	15



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