

Standards

DIN 8555 : MF 6-GF-60-GP

Chemical Composition of Weld Metal (Typical)

C	Si	Mn	Cr	Fe
0.40	2.00	0.60	9.0	Rest

Mechanical Properties

Hardness (as welded)
(HB)

600

Typical Base Material Grades

- Hardfacing of parts of earth and mineral mining machines, impact drilling and crushing devices, guide springs, edges of cutting tools, hard bucket edges and teeth, all of which are made of alloyed or unalloyed steels, as well as in other materials required to have high resistance to wear, debarking knives, agricultural tillage tools, earth moving bucket lips.

Features and Applications

- HARDCOR 600 M G is metal cored flux-cored wire for hardfacing
- High resistance to wear and to impact
- Alloy group is martensitic tool steel
- Weld metals of high hardness and high toughness
- Machinability of metal through grinding only
- It is excellent choice for components that are required to maintain a sharp edge
- Shielding Gas: CO₂ (M21)

Resistance Type and Level

Friction ■■■■■	High Temp. ■■■■■□	Corrosive ■□□□□	Machining ■■■■□□□
Impact ■■■■■	Thermo Shock ■■■■■□	Crack Resistance ■■■■■□□	

Operating Data

Diameter (mm)	Welding Current (A)	Voltage (V)	Stick-out (mm)
1.20	170 - 200	27.0 - 30.0	20.0 - 25.0
1.60	180 - 220	26.0 - 31.0	20.0 - 35.0

Current Type

FCAW / D.C. (+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
3030500030	1.20	0.047"	15
3030500031	1.60	0.062"	15

Approvals: SEPRO