

## AA GGG

CATEGORY	FCAW Flux-Cored
TYPE	Medium-alloy high-basicity 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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SUITABLE FOR	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
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APPROVALS	CE approved
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### 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	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	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		Spools	Packing	
	Voltage (V)	Current (A)		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
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