

Cored welding wire

The **BMI FCW600TIC® hardfacing cored wire** consists of a **flux-core powder encased in a metallic sheath**, designed for **open-arc welding** (without gas shielding).

Its **chemical composition** has been **specifically developed** to provide **exceptional resistance to mineral abrasion** in the deposit, combined with **excellent impact resistance**.

APPLICATIONS

A high chromium (Cr) content, combined with a uniform distribution of titanium carbides (TiC) in a martensitic matrix, gives the deposit excellent resistance to abrasion, erosion, and combined impact.

The BMI FCW600TIC® hardfacing cored wire can be used in single or multiple layers (up to 50 mm thickness). It ensures homogeneous fusion, good metal spread, no slag formation, and a very smooth bead. The formation of cracks in the deposited metal is normal for this type of product and does not affect its service performance. The deposit can be machined by grinding or finishing.

This alloy is **particularly suited for the mineral industries**, with applications such as **grinding hammers and rollers, excavators, disintegrators, clod breakers**, as well as for **gravel processing and road construction**.

TYPICAL CHEMICAL COMPOSITION WELD METAL

С	Mn	Si	Cr	Мо	Ti	V
1.8	1.2	0.8	6.5	0.8	5	0.2

TYPICAL MECHANICAL PROPERTIES

Hardness 1st Layer	Hardness 2nd Layer		
~ 55-56 HRC	~ 57 HRC		

OPERATING CONDITIONS

Cored Wire Ø	1.2	1.6	2.4	2.8
Voltage (V)	25-30	25-30	28-30	28-30
Current (A)	150-300	150-350	250-450	250-450

PACKAGING

25kg Coils for Ø2.4 and Ø2.8 15kg Spools for Ø1.2 and Ø1.6



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