



# FLUX CORED WIRE FOR HARDFACING

YAWATA HRC 60 is a flux cored welding wire. Flat, butt and horizontal welding position. Excellent weld quality, uniformed beads and low spatter. Mostly used for sprockets, tractor-link, idlers, crusher case and etc.

## Chemical Composition

C	Si	Mn	P	S	Cr	Mo	V
0.42	0.40	1.61	0.015	0.008	5.20	1.54	0.45

## Typical Hardness of Deposited Metal

Rockwell C (HRC)	Vickers (HV)	Heat Treatment
~58	~600	As Welded

## Size & Recommended Current Range

Welding Position	1.2mm	1.6mm
Current (A)	220~250	220~300
Voltage	28~30	30~32
Shielding Gas	CO2	CO2

## Packing

15kg spool

## Welding Positions



Flat Butt and Horizontal