


MA 600 Tig

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|------------------------------|--|--------------------|-------------|-------------|-------------|--------------------|----------|----|---------|-----|----|--------|-------------|-----------------|-------------|-------------|-------------|------------|---------|----------|----|-------|------|-----|------|--------|---|----|------|-----|------|---------|---|----|------|-----|------|---------|---|----|------|
| CATEGORY | GMAW-GTAW Solid wires | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| TYPE | Solid GTAW wire for hardfacing and rebuilding wornout parts. | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| APPLICATIONS | Rebuilding and hardfacing parts that are subject to abrasion combined with heavy impact. | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| PROPERTIES | MA 600 offers outstanding abrasion resistance combined with heavy shocks, despite the high hardness several layers can be applied without any risk of braking out or chipping of. In case of sensitive base material preheating is recommended at 300-400°C. Old hardfacing layers should be removed, clean or grind properly before welding. | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| CLASSIFICATION | AWS | A 5.21: ~ER FeCr-A | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | EN ISO | 14700: S Fe8 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | DIN: W.Nr. | 1.4718 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | DIN | 8555: MSG 2-GZ-60 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| SUITABLE FOR | Gear parts, recycling wear blocks, cutters, molds, pumps, stone crushers, knives, scissors, mixers etc. | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| APPROVALS | CE approved | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| WELDING POSITIONS: |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| WELD DEPOSIT WEIGHT % | <table><tr><td>C</td><td>Mn</td><td>Si</td><td>Cr</td><td>Ni</td><td>Mo</td></tr><tr><td>0.50</td><td>0.50</td><td>3.00</td><td>9.15</td><td>-</td><td>-</td></tr></table> | | | | | C | Mn | Si | Cr | Ni | Mo | 0.50 | 0.50 | 3.00 | 9.15 | - | - | | | | | | | | | | | | | | | | | | | | | | | | |
| C | Mn | Si | Cr | Ni | Mo | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 0.50 | 0.50 | 3.00 | 9.15 | - | - | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| MECHANICAL PROPERTIES | <table><tr><td>Shielding gas</td><td colspan="2">hardness</td><td>HB</td><td>HRc</td></tr><tr><td></td><td>HRc</td><td>HRc</td><td></td><td></td></tr><tr><td></td><td>untreated</td><td>1000°C/oil</td><td>unealed</td><td>3 layers</td></tr><tr><td>I1</td><td>54-60</td><td>62</td><td>250</td><td>~57</td></tr></table> | | | | | Shielding gas | hardness | | HB | HRc | | HRc | HRc | | | | untreated | 1000°C/oil | unealed | 3 layers | I1 | 54-60 | 62 | 250 | ~57 | | | | | | | | | | | | | | | | |
| Shielding gas | hardness | | HB | HRc | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | HRc | HRc | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | untreated | 1000°C/oil | unealed | 3 layers | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| I1 | 54-60 | 62 | 250 | ~57 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| WELDING PARAMETERS / PACKING | <table><tr><td colspan="3">Welding Parameters</td><td colspan="3">Packing</td></tr><tr><td>D (mm)</td><td>Length (mm)</td><td>Current (A) DC-</td><td>single (kg)</td><td>master (kg)</td><td>kg / pallet</td></tr><tr><td>1,6</td><td>1000</td><td>50-90</td><td>5</td><td>25</td><td>1000</td></tr><tr><td>2,0</td><td>1000</td><td>70-110</td><td>5</td><td>25</td><td>1000</td></tr><tr><td>2,4</td><td>1000</td><td>110-180</td><td>5</td><td>25</td><td>1000</td></tr><tr><td>3,0</td><td>1000</td><td>150-250</td><td>5</td><td>25</td><td>1000</td></tr></table> | | | | | Welding Parameters | | | Packing | | | D (mm) | Length (mm) | Current (A) DC- | single (kg) | master (kg) | kg / pallet | 1,6 | 1000 | 50-90 | 5 | 25 | 1000 | 2,0 | 1000 | 70-110 | 5 | 25 | 1000 | 2,4 | 1000 | 110-180 | 5 | 25 | 1000 | 3,0 | 1000 | 150-250 | 5 | 25 | 1000 |
| Welding Parameters | | | Packing | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| D (mm) | Length (mm) | Current (A) DC- | single (kg) | master (kg) | kg / pallet | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 1,6 | 1000 | 50-90 | 5 | 25 | 1000 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| 2,4 | 1000 | 110-180 | 5 | 25 | 1000 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 3,0 | 1000 | 150-250 | 5 | 25 | 1000 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| REDRYING TEMPERATURE | Not required | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| GAS ACC. EN ISO 14175: | I1 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |