

MA 600

CATEGORY GMAW-GTAW Solid wires

TYPE Solid welding 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-6-GZ-60-GPS

SUITABLE FOR Car recycling, cutters, pumps, stone crushers, knives, scissors, mixers etc.

APPROVALS CE approved

WELDING POSITIONS:



WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr
0.50	0.50	3.00	9.15

MECHANICAL PROPERTIES

Shielding gas	hardness			
	HRc untreated	HRc 1000°C/oil	HB unealed	HRc 3 layers
M21	54-60	62	250	~57

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool type	kg / spool	kg / pallet
1,0	18-28	80-280	K-300	15	1080
1,2	20-33	120-350	K-300	15	1080
1,6	24-36	180-380	K-300	15	1080

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: M12, M13, M21