

MA 600 (1.4718)

TYPE A newly designed hardfacing alloy based on the latest technology for rebuilding wornout parts with remarkable welding properties.

APPLICATIONS Rebuilding and hardfacing parts that are subject to abrasion combined with heavy impact. Excelent welding properties in both short and spray arc.

PROPERTIES **MA 600 (1.4718)** 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.

CLASSIFICATION

AWS	A 5.21: ER FeCr-A
EN ISO	14700: T Fe8
DIN: W.Nr.	1.4718
DIN	8555: MSG-6-GZ-60-GPS

SUITABLE FOR 600 HB hardfacing alloy against high impact and abrasion, stone crushers, car recycling, dredgers, buckets, cutting knives etc.

WELDING POSITIONS:



WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Mo
0.50	0.50	3.00	9.15	-	-

MECHANICAL PROPERTIES

With shielding gas acc. EN ISO 14175:	hardness			
	HRC	HRC	HB	HRC
M21	untreated 56-62	1000°C/oil	unealed	3 layers ~60

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		packing	Packing	
	Voltage (V) (DC+)	Current (A)	spool type	kg / spool	kg / pallet
1,2	14-29	100-290	K-300	15	1080
1,6	18-33	160-400	K-300	15	1080

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: M21