

CATEGORY	GMAW Solid wires	
TYPE	Solid welding wire for hardfacing and rebuilding hotworking tools..	
APPLICATIONS	Rebuilding and hardfacing parts that are subject to abrasion combined with higher temperatures.	
PROPERTIES	Abrasion combined with higher temperatures.	
CLASSIFICATION	EN ISO	14700: S Fe3
	DIN	8555: MSG 4-UM-60-65-ST
	F-nr	71
	W.Nr.	1.2343
SUITABLE FOR	Hotworking tools, high speed tool steels, HSS, aluminium press molts, dies, stamping tools, cutting tools, shear blades, cutters, knives, scissors.	
APPROVALS	No Approvals Found	

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Mn	Cr	Ni	Mo	V
0.4	0.4	5	4.5	1.1	0.5

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Hardness Rockwell C
As Welded /				Avg. 55

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	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 ACCORDING EN 14175	M21