

CATEGORY	GTAW 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 up to 550°C	
PROPERTIES	Abrasion combined with higher temperatures.	
CLASSIFICATION	EN ISO DIN W.Nr.	14700: S Fe8 8555: MSG-2-GZ-45-T 1.2367
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	Mo	Ti
0.2	0.6	6.2	3.2	0.6

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. 45

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	14-29	90-250	K-300	15	1080
1,2	16-32	120-320	K-300	15	1080
1,6	17-34	160-380	K-300	15	1080

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	M11