

HARDWELD 600

MIG/MAG Wires [GMAW]

Hardfacing and repairing

CLASSIFICATION: EN ISO 14700-A : S Fe8 DIN 8555 : MSG-6-GZ-60-GP W.Nr. : 1.4718	APPROVALS:	APPLICATION: Hardfacing and repairing
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- Solid wire for hardfacing, resistant to abrasion and high impact.
- The deposit is hard, without cracks and pores, resistant to wear at elevated temperatures.
- The deposit can only be machined by grinding.
- Due to the high concentration of Cr, the weld metal shows partial resistance to general corrosion.
- When making a multi-layer overlay, it is recommended to use a buffer layer with a lower hardness.
- In the case of hardfacing of old elements with previous hard deposits, it is recommended to remove them or make a buffer layer of a material of lower hardness, recommended weld metal type 307.

Application

Mixer blades, conveyor components, excavator bucket and grab teeth, crushing hammers and jaws, and more.

Typical chemical composition %

C	Si	Mn	Cr
0,45	3,0	0,40	9,5

Typical mechanical properties

Hardness	57 - 62 HRC /
Shielding gases acc. to EN ISO 14175	M21 - Ar + 15 - 25% CO2 /

Welding parameters and packing

∅	Weight of packet [kg]
1,0	15,0
1,2	15,0
1,6	15,0

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