HARDWELD 380

MIG/MAG Wires [GMAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14700-A : S Fe1 DIN 8555 : MSG-5-GZ-350		Hardfacing and repairing

- Low-alloyed and low-carbon solid wire for surfacing, ensuring hardness already in the first layer.
- In order to additionally increase the hardness, several layers can be surfacing.
- Recommended for hardfacing parts subject to medium impact and medium metal-to-metal wear.
- The deposit is resistant to abrasion and impact wear.

Application

For hardfacing overlay rolls of overhead cranes, elements that require a high and narrow deposit, which is additionally machined later. As a joining material where the weld must also be impact and abrasion resistant. As a buffer material for very hard overlays when high-alloy materials cannot be used. For mechanized hardfacing of rolls in the MIG/MAG or TIG method. Welded parts can be very small because the material works well at low currents in short-circuit mode.

Typical chemical composition %

C	Mn	Cr	Mo
0,07	0,90	6,00	0,90

Typical mechanical properties

Hardness	320-380 HB /
Welding positions	
Shielding gases acc. to EN ISO 14175	M12 - Ar + 0.5 - 5% CO2 / M13 - Ar + 0.5 - 3% O2 / M20 - Ar + 10% CO2 / M21 - Ar + 15 - 25% CO2 /

Welding parameters and packing

⌀	Welding current [A]	Voltage [V]	Weight of packet [kg]
1,0	160-260	18-27	15,0
1,2	220-300	21-31	15,0
1,6	260-380	24-34	15,0

METALWELD-FIPROM POLSKA spółka z o.o.

ul. Mikołajczyka 57, 41-200 Sosnowiec

+48 (32) 297 75 50 - 51

+48 (32) 297 75 88

export@metalweld.pl