

## CLASSIFICATIONS

DIN 8555 : MSG 1-GZ-250

## DESCRIPTION

- Cr-Mo alloyed steels (1.5%-0.5%) resistant to high temperature, wear, pressure and shocks
- Good resistance to cracking and to the attack of sulphures agents
- Guide rollers, excavators, screw conveyers, gears, moulds, rolling surfaces, etc
- Before the application of welding, it is recommended pre-heating of 300°C
- If necessary , post- weld stress relief should be made at 690°C
- Shielding Gas: Ar+CO<sub>2</sub> mix gases can be used

## CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.09 | Si: 0.55 | Mn: 1.00 | Cr: 3.00 | Mo: 1.00

## MECHANICAL PROPERTIES

**Hardness** (after working)  
(HRC)

22 - 27

## WELDING POSITIONS



## CURRENT TYPE

MAG D.C.(+)

## OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
1011100194	1.20	0.047"	15	BS 300 Spool