

### CLASSIFICATIONS

DIN 8555 : MSG 3-GZ-55-T  
 : WSG 3-GZ-55-T

### DESCRIPTION

- Application areas are cold and hot work tool steels which are used in machine parts, cold and hot cutting blades, extrusion dies, rollers, steel castings and moulds
- It is hard facing wire which has high abrasion resistance and keep hardness at high temperatures
- 400°C pre-heat temperature must be done before welding if it is needed, stress relieving must be done at 550°C after welding
- Shielding gas: MAG: Ar+CO<sub>2</sub>  
 TIG: Ar

### CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.35 | Si: 0.40 | Mn: 1.00 | Cr: 7.00 | Mo: 1.10

### MECHANICAL PROPERTIES

**Hardness** (as welded)  
 (HRC)

53 -58

### BASE MATERIALS

- 1.2510-1.2363-1.2721-1.2379-1.2842-1.1730-1.2990

### WELDING POSITIONS



### CURRENT TYPE

MAG D.C.(+) / TIG D.C. (-)

### OPERATING DATA

| Product Code | Diameter x Length<br>(mm) / (inch) |            | Package Weight (Kg) |                    |
|--------------|------------------------------------|------------|---------------------|--------------------|
|              |                                    |            | MAG                 | TIG                |
| 1011100212   | 1.00                               | 0.040"     | BS 300<br>15 Kg     | Carton Box<br>5 Kg |
| 1011100213   | 1.20                               | 0.047"     |                     |                    |
| 1011100214   | 1.6 x 1000                         | 1/16 x 39" |                     |                    |
| 1011100215   | 2.0 x 1000                         | 5/64 x 39" |                     |                    |
| 1011100216   | 2.4 x 1000                         | 3/32 x 39" |                     |                    |