

CLASSIFICATIONS

EN 14700 : T Z Fe 8
DIN 8555 : MF 3-50-CKTZW

DESCRIPTION

- Applicability in hardfacing for protection against wear of steels working at temperature sup to 650°C
- Existence of high amounts of Cr, Co, Mo alloys in weld metal
- High resistance to cracking
- Oxidation-and creep resistant behaviours at high temperatures
- High resistance against sliding wearof metallic object
- High resistance to thermal shock
- Shielding Gas: M 13 (Ar+1%O₂)

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.1 | Si: 0.7 | Mn: 0.4 | Cr: 15.0 | Ni: + | Mo: 3.2 | Co: 14 | Fe: Rest

MECHANICAL PROPERTIES

Hardness

(As Welded) (HRC)	(After Working) (HRC)
48 - 50	53

BASE MATERIALS

- Hardfacing of hot- work tool steels, forging dies, hot-shearing tools, punch tools, punch tools, rollers, hot hardening treatment, steel mili rolls Continuous casting driving rolls, dies, mandrels, forming tools, pumps

WELDING POSITIONS



OPERATING DATA

Diameter (mm)	Welding Current (A)	Voltage (V)	Stick-out (mm)
1.20	170 - 200	27 - 30	15 - 25

CURRENT TYPE

FCAW / D.C. (+)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
1011100292	1.20	0.047"	15