

CLASSIFICATIONS

EN 14700 : T Fe4
DIN 8555 : TIG 3-GF-60-T

DESCRIPTION

- It is hardfacing TIG wire which has high abrasion resistance and keep hardness at high temperatures
- Application range is cold and hot work tool steels which are used in machine parts, cold and hot cutting blades, extrusion dies, rollers, steel casings, moulds, tools and metal-to-metal friction applications
- Weld metal is machinable by grinding
- It is recommended that pre-heating at 400°C before welding and very slow cooling after welding
- If necessary, it is recommended the stress relief annealing at 550°C after welding
- Shielding Gas : Argon

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.55 | Si: 0.5 | Mn: 0.4 | Cr: 4.0 | Mo: 8.0 | W: 1.60

MECHANICAL PROPERTIES

Hardness (as welded)
(HRC)

56 - 60

WELDING POSITIONS



CURRENT TYPE

TIG D.C. (-)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)	Package Type
2010400002	2.40 x 1000	3/32 x 39"	5	Carton Box