MIG HB50

Old reference: MIG R500B

Classification

DIN 8555 : MSG 2-GZ-50
EN 14700 : S Fe2

Material N° : 1.8425

Description & Applications

Solid wire with copper coated for surfacing by the GMAW process.

Main applications: For hardfacing of civil engineering equipments such as shovel and bucket teeth, bucket edges, excavators as well as cutting edges.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Al	Ti	P	S	Fe
1.1	0.5	1.9	1.8	0.1	0.2	<0.02	<0.01	Rem.

All Weld Metal Mechanical Properties

Hardness
~50 HRC

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
GMAW = +	0.8 1.0 1.2 1.6	60-100 150-170 150-220 180-270	18-21 25-28 26-28 26-32	EN 439: M21 (Ar/CO_2) 12-15 l/min

Ind.10

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