MIG HBC62

Classification

DIN 8555 : MSG 4-GZ-60-S
EN 14700 : S Fe4

Material N° : 1.3348

Description & Applications

Solid wire for GMAW for surfacing. Composition of high speed steel, used for hardfacing cold working tools as lathe tools, drilling tools, cutting tools.

Main applications: Hardfacing and repairing of high speed steels like 85WMoCrV6.5.4.2, 1.3339, 1.3333 and others.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Mo	V	W	Fe
1.0	0.4	0.2	3.6	8.5	1.8	1.6	Rem.

All Weld Metal Mechanical Properties

Hardness
~62 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	100-150 150-190 150-220 180-270	22-27 25-28 25-28 26-32	EN 439: M1 (Ar+2%CO_2) 12-15 l/min

Tool steels have to be preheated to 350-450°C, depending on the thickness and composition.

Ind.10

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