TIG HB56HT

Classification

EN 14700 : S Fe6 Material N° : ~1.2343

Description & Applications

Solid rod for TIG hardfacing of steels with similar chemical composition. The weld deposit distinguishes itself by its toughness and heat resistance. Therefore this grade is used for overlay and builds up of machinery parts and tools subject to impact, compression and wear used at operating temperatures up to 500°C.

Main applications: For trimming dies, for building up hammers, dies, swages, hot shear blades, rollers, cast moulds.

Base materials:

High strength carbon steels and hot working steels:

Material N°	*DIN classification*	*Material N°*	*DIN classification*
1.2311	40CrMnMo 7	1.2367	X38CrMoV 5 3
1.2343	X38CrMoV 5 1	1.2606	X37CrMoW 5 1
1.2344	X40CrMoV 5 1	1.2713	55NiCrMoV 6
1.2365	X32CrMoV 3 3	1.2714	56NiCrMoV 7

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Mo	Nb	Ti	P	S	Fe
Min										
Max	2.5		3	10	3	10				Rem.
Type	0.35	0.40	1.1	7.0	2.2	0.001	0.30	0.020	0.010	Rem.

All Weld Metal Mechanical Properties

Hardness (as welded)
52-57 HRC

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min

Preheat the workpiece to 250-400°C depending on thickness and ally composition. Keep low temperature during welding and let the workpiece cool slowly.

Subsequent machining is possible by gridding or with tungsten carbide tool.

FT En-TR10-170720

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