

## MA 500

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** Solid welding wire for rebuilding and hardfacing.

**APPLICATIONS** Rebuilding parts that are subject to abrasion combined with heavy impact.

**PROPERTIES** Weld deposit with high carbon content offering excellent weldability.

**CLASSIFICATION**

AWS	A 5.21: no standard
EN ISO	14700: ~S Fe14
DIN: W.Nr.	1.8425
DIN	8555: MSG 2-GZ-500

**SUITABLE FOR** Crushers, bucket teeth, hammers, crushers, pressure blocks etc.

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD DEPOSIT WEIGHT % (M21)**

C	Mn	Si	Cr	Ni	Mo
1.10	1.90	0.35	1.80		

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
AW							470-530

AW: as welded

**WELDING PARAMETERS / PACKING**

D (mm)	Welding Parameters		spool type	Packing	
	Voltage (V)	Current (A)		kg / spool	kg / pallet
1,2	23-31	190-280	K-300	15	1080
1.6	25-34	230-370	K-300	15	1080

**REDRYING TEMPERATURE** not required