

## MA 600

**CATEGORY** GMAW-GTAW Solid wires

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

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

**PROPERTIES** MA 600 offers outstanding abrasion resistance combined with heavy shocks, despite the high hardness several layers can be applied without any risk of braking out or chipping of. In case of sensitive base material preheating is recommended at 300-400°C. Old hardfacing layers should be removed, clean or grind properly before welding.

**CLASSIFICATION**

AWS	A 5.21: ER FeCr-A
EN ISO	14700: S Fe8
DIN: W.Nr.	1.4718
DIN	8555: MSG-6-GZ-60-GPS

**SUITABLE FOR** Car recycling, cutters, pumps, stone crushers, knives, scissors, mixers etc.

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD DEPOSIT WEIGHT %**

C	Mn	Si	Cr
0.50	0.50	3.00	9.15

**MECHANICAL PROPERTIES**

Shielding gas	hardness			
	HRC	HRC	HB	HRC
	untreated	1000°C/oil	unealed	3 layers
M21	54-60	62	250	~57

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool type	kg / spool	kg / pallet
1,0	18-28	80-280	K-300	15	1080
1,2	20-33	120-350	K-300	15	1080
1,6	24-36	180-380	K-300	15	1080

**REDRYING TEMPERATURE** not required

**GAS ACC. EN ISO 14175:** M12, M13, M21