

MA 600 Tig

CATEGORY GMAW-GTAW Solid wires

TYPE Solid GTAW 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 2-GZ-60

SUITABLE FOR Gear parts, recycling wear blocks, cutters, molds, pumps, stone crushers, knives, scissors, mixers etc.

APPROVALS CE approved

WELDING POSITIONS:



WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Mo
0.50	0.50	3.00	9.15	-	-

MECHANICAL PROPERTIES

Shielding gas	hardness			
	HRC untreated	HRC 1000°C/oil	HB unealed	HRC 3 layers
I1	54-60	62	250	~57

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) DC-	single (kg)	master (kg)	kg / pallet
1,6	1000	50-90	5	25	1000
2,0	1000	70-110	5	25	1000
2,4	1000	110-180	5	25	1000
3,0	1000	150-250	5	25	1000

REDRYING TEMPERATURE Not required

GAS ACC. EN ISO 14175: I1