

MA 617

CATEGORY	GMAW-GTAW Solid wires
TYPE	Stainless welding wire for hard-facing against abrasion combined with corrosion and heavy impact loads.
APPLICATIONS	Car recycling, cutters, pumps, stone crushers, clay extruders, cutting tools, food machinery etc. .
PROPERTIES	MA 617 offers outstanding metal to metal wear resistance combined with impact, despite the high hardness several layers can be applied without risk of chipping of. The weld deposit is temperature resistant up to 500°C and hardness will remain very well at increased temperatures. Scale resistant till 900°C. MA 617 is best to be used with Ar/Co2 - 98-2.

CLASSIFICATION	AWS	A 5.21: no standard
	EN ISO	14700: S Fe8
	DIN: W.Nr.	1.4122
	DIN	8556: X35CrMo17

SUITABLE FOR	Pumps, clay screws, seats, valves, cutting edges, rebuilding steel mill rollers, dies, mixing tools for sand, bentonit, clay, food machinery etc.
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APPROVALS	CE approved
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WELDING POSITIONS:	
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WELD METAL ANALYSIS %	C	Other	Mo	Cr
	0.38	< 5	0.8	17

MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V	Hardness
	AW				-20°C -40°C	500°C HRc
						40 HRc 48-55

AW: as welded

WELDING PARAMETERS / PACKING	Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet	
1.2	23-32	190-280	K/D 300	15	1080	
1.6	26-34	230-360	K/D 300	15	1080	

REDRYING TEMPERATURE	not required
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