

## MA 650

CATEGORY	GMAW-GTAW Solid wires	
TYPE	Solid welding wire for hardfacing and rebuilding wornout parts.	
APPLICATIONS	Rebuilding or cladding wornout parts that needs to sustain high abrasion and medium impact.	
PROPERTIES	Solid welding wire for hardfacing parts that are subject to high abrasion, the addition of tungsten, vanadium and molybdenum offers better cutting properties and higher hardness. Hardness: 570-660 HB	
CLASSIFICATION	AWS	A 5.21: ~ER Fe-8
	EN ISO	14700: S Fe8
	DIN: W.Nr.	1.2606
	DIN	8555: MSG 3-GZ-60T

**SUITABLE FOR** Mixer blades, cutting knives, pumps, loader teeth, screws, sludge disposal, carbidge recycling etc.

**APPROVALS** CE approved

**WELDING POSITIONS:**



C	Mn	Si	Cr	W	Mo	V
0,35	0,4	1,1	5,2	1,3	1,4	0,4

### 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 HRc
				-20°C	-40°C	-60°C	
AW							57-60

AW: as welded

### WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		spooling type	Packing	
	Voltage (V)	Current (A)		kg / spool	kg / pallet
1,0	21-27	120-230	K-300	15	1080
1,2	24-31	170-290	K-300	15	1080
1,6	26-34	230-370	K-300	15	1080

**REDRYING TEMPERATURE** not required

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