

MA HSS

CATEGORY GMAW-GTAW Solid wires

TYPE Solid drawn hardfacing alloy based on a High Speed Steel (HSS) weld deposit.

APPLICATIONS Cutting edges, tool making, gouges, turning chisel, broaches, schredder knives, scissors etc.

PROPERTIES Extreme hard and heat resistant alloy that offers excellent cutting properties when cutting steel cables, bars, wooden bars etc. The alloy is only machinable by grinding.

CLASSIFICATION

AWS	A 5.21: ~ER Fe-6
EN ISO	14700: S Fe4
DIN: W.Nr.	1.3348
DIN	8555: MSG 4-UM-60(65W)-ST

SUITABLE FOR 57-62 HRc hardfacing alloy for steel cutting knives, scissors, HSS, high speed tool steel, 1.3348, molds, edges and repairs on ; X85WDCV06-04-02 ; V6Mo5Cr4V2 ; HS 6-5-2 ; M2, J438B; X85WDCV06-04-02 ; BM2 ; SKH 51 ; R 6 M 5

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS (WEIGHT %)

C	Mn	Si	Cr	Mo	V	W
1,00	0,30	0,30	4,00	8,30	1,90	1,80

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc
				-20°C	-40°C	-60°C	
as welded (3 layers)							57-62

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters			Packing	
	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1,0	18-27	120-240	KD-300	15	1080
1,2	22-31	160-290	KD-300	15	1080

REDRYING TEMPERATURE not required

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