

MA SS 2343

CATEGORY GMAW-GTAW Solid wires

TYPE Solid welding wire for hardfacing and rebuilding hotworking tools..

APPLICATIONS Rebuilding and hardfacing parts that are subject to abrasion combined with higher temperatures.

CLASSIFICATION
 AWS A 5.21: (AISI J 438 b) H 11
 EN ISO 14700: S Fe3
 DIN: W.Nr. 1.2343
 DIN 8555:

SUITABLE FOR Hotworking tools, high speed tool steels, HSS, aluminium press molts, dies, stamping tools, cutting tools, shear blades, cutters, knives, scissors.

APPROVALS CE approved

WELDING POSITIONS:



WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Mo	V
0.38	0.45	0.95	5.2	1.10	0.45

MECHANICAL PROPERTIES

Shielding gas	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	
M21							52-57

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Packing		
	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: M21