

MA SS 2367

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 up to 550°C

CLASSIFICATION

AWS	A 5.21:
EN ISO	14700: S Fe 8
DIN: W.Nr.	1.2367
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	Ti
0.25	0.60	0.30	5.0	3.60	0.60

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	
							42-47

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool type	kg / spool	kg / pallet
1,0	14-29	90-250	K-300	15	1080
1,2	16-32	120-320	K-300	15	1080
1,6	17-34	160-380	K-300	15	1080

REDRYING TEMPERATURE Not required

GAS ACC. EN ISO 14175: M11, S1, S3