

## SS 60 TIG

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** High-Mo alloyed flux cored wire on a „High Speed steel basis“ (HSS) for extreme hard deposits on parts subject to strong impact and high pressure, weldable without protective gas.

**APPLICATIONS** Rebuilding wornout parts that faces wear and impct combined with increased working temperatures. (Excellent alloy for making cutting tools out of mild steel)

**CLASSIFICATION**

AWS	A 5.21:
EN ISO	14700: S Fe4
DIN	8555: 4-GZ-60-ST

**SUITABLE FOR** 60 HRC hardfacing alloy for cutting edges, wood shredders, knives, recycling equipment, HSS, High speed tool steel alloy. Cutting edges on knives and share blades, pumps, mixer blades, wood shredders etc.. (Excellent alloy for making cutting tools out of mild steel)

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

C	Mn	Si	Cr	W	Mo	V
1.0	0.7	0.4	4.50	2	8.0	1.50

**ALL WELD METAL 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							60

AW: as welded

**WELDING PARAMETERS / PACKING**

D (mm)	Welding Parameters		Packing
	Voltage (V)	Current (A)	kg / package
1.6			5
2.0			5