

MH 361

Gazaltı (MIG/MAG) Kaynak Teli - Hardfacing Applications

Standards

EN 14700	S Fe8
TS EN 14700	S Fe8
DIN 8555	MSG 6-GZ-60-GPS
DIN M. No.	1.4718

Properties and Applications

Gas metal arc (MIG/MAG) welding wire especially developed for hardfacing of parts subjected to high metal-to-metal friction, mineral abrasion and moderate impact. Weld metal can retain its hardness at high temperatures, till 600°C. Weld metal can be grinded and machined by diamond tools. A tough buffer layer with FCW 30 is recommended before hardfacing, if base metal has high carbon and low weldability. Heat treatment after hardfacing will decrease as-welded hardness.

Typical Applications: Ceramic tile moulds, mixer blades, crushers, earth moving equipments, hot cut-offs, shear blades, dies for pressure casting, scraper blades, conveyors, rollers.



Typical Chemical Values of Weld Metal

Type of Analysis	C	Si	Mn	Cr	Fe
Weld Deposit	0.40	2.40	0.35	8.60	88.25

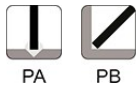
Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Hardness (HRC)
As welded	C1	59
As welded	M21	58

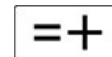
* Chemical composition and mechanical properties are valid when using shielding gas.

Application Information

Welding Positions



Polarity:



Protection Gas:
M12 M21

Welding Parameters & Efficiency

Diameter (mm)
1.00
1.20

Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
28000DJAM2	1.00	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
28000EJAM2	1.20	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)

Storage & Re-Drying Information

Shouldn't be exposed to high static load and impact.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.