

# 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

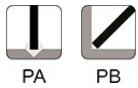
### Typical Mechanical Values of Weld Metal

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

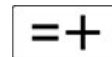
\* Chemical composition and mechanical properties are valid when using shielding gas.

### 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.