

# MIG 600HB



## Classification

DIN 8555 : MSG 6 GZ-60

Material N° : 1.4718

EN : X45CrSi 9

## Description & Applications

Solid wire electrode –copper coated- for surfacing by the GMAW process.

Used for hardfacing parts subject to high impact and medium abrasion.

A kind of an universal hardfacing wire used in quarries, mines, steel works, cement works, crushing plants, the wood industry, in the car industry and others.

Special applications are: Hardfacing of block presses, crusher jaws, wheel rims, rollers, caterpillar tracks, ploughshares, running surfaces, cutting edges etc

## Typical Chemical Composition ( % )

C	Si	Mn	Cr	Fe
0.42	2.8	0.4	8.5	base

## All Weld Metal Mechanical Properties

Hardness

~60 HRC

## Welding Current & Instructions

Welding mode	Wire Ø ( mm )	Welding parameters		Shielding Gas
		Pulsed arc ( A )	( V )	
GMAW =+	1.0	150-170	25-28	EN 439: M21 ( Ar/CO2 ) 12-15l/min
	1.2	150-220	26-28	

Tool steels have to be preheated to 300-400°C, depending on the thickness and composition.



Ind.05

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