



MIG 819 BS

Classification

EN 14700 : S Fe3

Material N° : 1.6773

Description & Applications

Solid wire for GMAW for welding and hardfacing. Product of high purity for welding without micro porosity.

Main applications: For cold working tools, swages for forging, for punching tools as well as for moulds for plastics. Especially designated to repair and to surface the parent material 36NiCrMo16, 1.6773.

Available as copper coated or bare wire.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	P	S	Fe
0.35	0.3	0.4	1.7	3.8	0.3	<0.015	<0.010	Rem.

All Weld Metal Mechanical Properties

Hardness (As welded)

~48 HRC

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	0.8	60-100	18-21	EN 439: M21 (Ar/CO ₂) 12-15 l/min
	1.0	150-170	25-28	
	1.2	150-220	26-28	
	1.6	180-270	26-32	

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