



MIG HB25

Old reference: MIG R250B

Classification

DIN 8555 : MSG 1-GZ-250-P Material N° : 1.8401
 EN 14700 : S Fe1

Description & Applications

Solid wire with copper coated for GMAW for surfacing. Tough deposit, easy to machine.

Main applications: Used for surfacing of rails, shafts, rollers as well as for semi-hard build up and intermediate layers.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Al	Ti	P	S	Fe
0.3	0.5	1.1	1.0	0.1	0.2	<0.02	<0.01	Rem.

All Weld Metal Mechanical Properties

Hardness
 225-275 HB

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
GMAW = +	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	

Ind.10



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