



# MIG HB35

Old reference: MIG R350B

## Classification

DIN 8555 : MSG 2-GZ-350-P      Material N° : 1.8405  
 EN 14700 : S Fe2

## Description & Applications

Solid wire with copper coated for GMAW for surfacing.

**Main applications:** Hardfacing of pressing and stamping tools.

## Typical Chemical Composition ( % )

C	Si	Mn	Cr	Al	Ti	P	S	Fe
0.7	0.5	1.9	1.0	0.1	0.2	<0.02	<0.01	Rem.

## All Weld Metal Mechanical Properties

Hardness  
 330-370 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 <sub>2</sub> ) 12-15 l/min
	1.0	150-170	25-28	
	1.2	150-220	26-28	
	1.6	180-270	26-32	

Preheat the parent metal, depending on the carbon-equivalent and thickness, up to about 350°C.

Ind.10



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