



MIG HB60

Old reference: MIG 600HB

Classification

DIN 8555 : MSG 6 GZ-60
 EN 14700 : S Fe6

Material N° : 1.4718

Description & Applications

Solid wire with copper coated for GMAW for surfacing. Used for hardfacing parts subject to high impact and medium abrasion. A kind of a universal hardfacing wire used in quarries, mines, steel works, cement works, crushing plants, the wood industry, in the car industry and others.

Main applications: 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	Rem.

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/CO ₂) 12-15 l/min
	1.2	150-220	26-28	

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

Ind.10



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