



## MIG MV5S

### Classification

DIN 8555 : MSG 3-GZ-60-P

EN 14700 : S Fe4

### Description & Applications

Solid wire for GMAW for hardfacing. Product of high purity, without copper coating, for welding without micro porosity. Mainly used for build up on equipments stressed by high impact and abrasion. Resistant to temperatures up to 550°C.

**Main applications:** Moulds for plastic injections, cold working tools, shredder hammers.

### Typical Chemical Composition ( % )

C	Cr	Mo	W	V	Fe
0.5	5.0	1.3	1.3	0.4	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)	
MIG = +	0.8	60-100	18-21	EN 439: M21 (Ar/CO <sub>2</sub> ) 18 l/min
	1.0	150-170	25-28	
	1.2	150-220	26-28	
	1.6	19-300	26-32	

Preheating of massive parts to 150-300°C is recommended. Maintain temperature during welding and then cool down in furnace if possible, to reduce cracks risks.

For build-up layers use MIG R250B.

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