



TIG HB25

Old reference: TIG R250B

Classification

DIN 8555 : WSG 1-GZ-250-P
EN 14700 : S Fe1

Material N° : 1.8401

Description & Applications

Copper coated solid rod for TIG welding to surfacing. Tough deposit, easy to machine.

Main applications: Used for surfacing of rails, shafts, rollers, crane wheels 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	Shielding Gas
TIG = -	Ar : 6-12 l/min

ind.10



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