



TIG HB35

Old reference: TIG R350B

Classification

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

Description & Applications

Copper coated solid rod for TIG welding to 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	Shielding Gas
TIG = -	Ar : 6-12 l/min

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

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