



TIG HB50

Old reference: TIG R500B

Classification

DIN 8555 : WSG 2-GZ-50
EN 14700 : S Fe2

Material N° : 1.8425

Description & Applications

Copper coated solid rod for TIG welding to surfacing.

Main applications: Hardfacing of civil engineering equipments such as shovel and bucket teeth, bucket edges, excavators as well as cutting edges.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Al	Ti	P	S	Fe
1.1	0.5	1.9	1.8	0.1	0.2	<0.02	<0.01	Rem.

All Weld Metal Mechanical Properties

Hardness
~50 HRC

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min

ind.10



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