



TIG HBF17

Old reference: TIG HBCrMo17-1

Classification

DIN 8555 : WSG 6-GZ-50-RZ Material N° : 1.4122
EN 14700 : S Fe8

Description & Applications

Solid rod for TIG welding to surfacing. Used for hardsurfacing parts subject to corrosion and heat as well as cold working tools. For gas, water and steam valves with service temperatures up to 500°C.

Main applications: Hardfacing and welding of Base metals X55CrNiMoV12, X55Cr14, X160CrMoV12.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Mo	Fe
0.4	0.5	0.5	16.5	1.1	Rem.

All Weld Metal Mechanical Properties

Hardness
~53 HRC

Welding Current & Instructions

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

Tool steels have to be preheated to 350-450°C, depending on the thickness and composition.

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