



MIG 819 BS*

Classification

EN 14700 : S Fe3

Material N° : 1.6773

Description & Applications

Solid wire for GMAW hardfacing steels with similar chemical composition such as 36NiCrMO16, 45NiCrMo18, 60NiCrMo11.

Product of high purity for welding without micro porosity.

Main applications: Used for cold working tools, swages for forging and punching tools as well as for moulds for plastics.

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	W	V	Nb	Co	Ti	P	S	Fe
Min	0.1			1										
Max	0.5		3	15	5	5	10	1.5	3	13				Rem.
Type	0.35	0.30	0.40	1.7	3.8	0.30	0.001	0.001	0.001	0.001	0.001	0.015	0.010	Rem.

All Weld Metal Mechanical Properties

Hardness (As welded)

~48 HRC

Welding Current & Instructions

	Ø (mm)	Welding parameters		Shielding gas
		Current (A)	Voltage (V)	
GMAW = +	0.8	60 - 100	18 - 21	ISO 14175: M21 (Ar/CO ₂) 12-15 l/min
	1.0	150 - 170	25 - 28	
	1.2	150 - 220	26 - 28	
	1.6	180 - 270	26 - 32	

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