



MIG HB25

Old reference: MIG R250B

Classification

EN 14700 : S Fe1

Material N° : 1.8401

Description & Applications

Copper coated solid wire for GMAW welding to surfacing. Tough deposit, easy to machine.

Main applications: 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	Ni	Mo	W	V	Ti	P	S	Fe
Min												
Max	0.4		4.5	3.5	3	1	1	1				Rem.
Type	0.25	0.50	1.0	1.0	0.01	0.05	0.01	0.005	0.20	0.015	0.005	Rem.

All Weld Metal Mechanical Properties

Hardness (as welded)

225-275 HB

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	

FT En-MR11-200408

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.

www.fsh-welding.com - info@fsh-welding.fr