



## MIG HB35

Old reference: MIG R350B

### Classification

EN 14700 : S Fe2

### Description & Applications

Copper coated solid wire for GMAW hardfacing of construction or cast steels. Good wear resistance under pressure combined to shocks.

**Main applications:** Hardfacing of pressing and stamping tools.

### Typical Chemical Composition ( % )

	C	Si	Mn	Cr	Ni	Mo	Cu
Min	0.4						
Max	1.5		3	7	4	1	1
Type	0.07	0.40	0.50	5.8	0.05	0.60	0.10
	W	Ti	V	Co	P	S	Fe
Min							
Max	1		1	1			Rem.
Type	0.01	0.005	0.01	0.005	0.015	0.010	Rem.

### All Weld Metal Mechanical Properties

Hardness (as welded)  
35 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 <sub>2</sub> ) 12-15 l/min
	1.0	150 - 170	25 - 28	
	1.2	150 - 220	26 - 28	
	1.6	180 - 270	26 - 32	

Preheat the parent metal, depending on the carbon-equivalent and thickness, at 300-400°C.

FT En-MR12-200408

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[www.fsh-welding.com](http://www.fsh-welding.com) - [info@fsh-welding.fr](mailto:info@fsh-welding.fr)