MIG HB48HT

Classification

EN 14700 : S Fe8 Material N° : ~1.2367

Description & Applications

Solid wire for hardfacing steels of similar chemical composition. The weld deposit distinguishes itself by its toughness and heat resistance. Therefore this grade is used for overlay and builds up of machinery parts and tools subject to impact, compression and wear used at operating temperatures up to 550°C.

Main applications: For forging and drawing dies, for building up hammers, dies, swages, hot shear blades, rollers, cast moulds.

Base materials

High strength carbon steels and hot working steels

Material N°	DIN classification	Material N°	DIN classification
1.2311	40CrMnMo 7	1.2367	X38CrMoV 5 3
1.2343	X38CrMoV 5 1	1.2606	X37CrMoW 5 1
1.2344	X40CrMoV 5 1	1.2713	55NiCrMoV 6
1.2365	X32CrMoV 3 3	1.2714	56NiCrMoV 7

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Mo	W	Nb	V	Ti	P	S	Fe
Min	0.2			5								
Max	2		3	20	5	2	10	2				Rem.
Type	0.25	0.30	0.60	5.1	3.6	0.001	0.001	0.001	0.60	0.020	0.010	Rem.

All Weld Metal Mechanical Properties

Hardness (as welded)
42-47 HRC

Welding Current & Instructions

	Ø (mm)	Welding parameters		Shielding gas
		Current (A)	Voltage (V)	
GMAW = +	1.2 1.6	150 - 220 190 - 300	26 - 28 26 - 32	ISO 14175: M11 (Ar/CO_2) 18 l/min

Preheat the workpiece to 250-400°C depending on thickness and alloy composition. Keep low temperature during welding and let the workpiece cool slowly.

Subsequent machining is possible by gridding or with carbide tool.