



## MIG HB50

Old reference: MIG R500B

### Classification

EN 14700 : S Fe2

### Description & Applications

Copper coated solid wire for GMAW hardfacing of construction steels or Mn steels. Excellent wear resistance.

**Main applications:** Hardfacing of civil engineering equipments such as shovel and bucket teeth, bucket edges, excavators as well as cutting edges.

### Typical Chemical Composition ( % )

	C	Si	Mn	Cr	Ni	Mo	Cu
Min	0.4						
Max	1.5		3	7	4	1	1
Type	1.1	0.45	1.9	1.8	0.05	0.01	0.05
	W	Ti	V	Co	P	S	Fe
Min							
Max	1		1	1			Rem.
Type	0.01	0.20	0.01	0.005	0.015	0.010	Rem.

### All Weld Metal Mechanical Properties

Hardness (as welded)

47-52 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, up to 300-400°C.

**DO NOT PREHEAT MN STEELS!**

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