



MIG HB60

Old reference: MIG R600B

Classification

EN 14700 : S Fe8

Description & Applications

Copper coated solid wire for GMAW. Used for hardfacing parts subject to high impact and medium abrasion. A kind of a universal hardfacing wire used in quarries, mines, steel works, cement works, crushing plants, the wood industry, in the car industry and others.

Main applications: Hardfacing of block presses, crusher jaws, wheel rims, rollers, caterpillar tracks, ploughshares, running surfaces, cutting edges etc

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	P	S	W	V	Ti	Nb	Fe
Min	0.2			5										
Max	2		3	20		5				2	2		10	Rem.
Type	0.45	3.0	0.45	9.5	0.20	0.10	0.20	0.02	0.01	0.02	0.06	0.01	0.01	Rem.

All Weld Metal Mechanical Properties

Hardness (As welded)
~60 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	

Tool steels have to be preheated to 300-400°C, depending on the thickness and composition.

FT En-MR14-200408

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