



MIG HBC62

Old reference: MIG F820D

Classification

EN 14700 : S Fe4

N° de Mat. : 1.3348

Description & Applications

Solid wire for MIG hardfacing and repairing of high speed steels like 85WMoCrV6.5.4.2, 1.3339, 1.3333 and others.

Main applications: For hardsurfacing cold working tools as lathe tools, drilling tools, cutting tools.

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	W	V	Co	Ti	P	S	Fe
Min	0.2			2									
Max	1.5		3	10	4	10	20	4	5				Rem.
Type	1.0	0.40	0.30	3.6	0.001	8.7	1.7	1.85	0.001	0.001	0.02	0.01	Rem.

All Weld Metal Mechanical Properties

Hardness (as welded)
~62 HRC

Welding Current & Instructions

	Ø (mm)	Welding parameters		Shielding gas
		Current (A)	Voltage (V)	
GMAW = +	0.8	100 - 150	22 - 27	ISO 14175: M21 (Ar/CO ₂) 12-15 l/min
	1.0	150 - 190	25 - 28	
	1.2	150 - 220	25 - 28	
	1.6	180 - 270	26 - 32	

Tool steels have to be preheated to 350-450°C, depending on the thickness and composition.

FT En-MR16-200408

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