



## MIG MV5S\*

### Classification

EN 14700 : S Fe4

### Description & Applications

X50CrMoW5 solid wire type for GMAW welding and hardfacing. Resistant to temperatures up to 550°C. Product of high purity for welding without microporosity. Mainly used for build up on equipments stressed by high impact and metal/metal abrasion.

Product of high purity for welding without micro porosity.

**Main applications:** Moulds for plastic injections, cold or hot working tools, shredder hammers...

### 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	0.50	0.90	0.40	5.0	0.001	1.3	1.3	0.40	0.001	0.001	0.010	0.002	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 <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	

Pre-heating at 300-400°C of massive parts. Maintain temperature during welding and cold slowly to limit cracks during cooling.

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