



TIG 819BS*

Classification

EN 14700 : S Fe3

Material N° : 1.6773

Description & Applications

Solid rod for TIG hardfacing of low alloyed steels with similar chemical composition like 36NiCrMo16 (ZNCD16), 45NiCrMo18, 60NiCrMo11. Product of high purity for welding without micro porosity.

Main applications: Hardfacing cold working tools, swages for forging and punching tools as well as for moulds for plastics.

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	W	V	Nb	Co	Ti	P	S	Fe
Min	0.1			1										
Max	0.5		3	15	5	5	10	1.5	3	13				Rem.
Type	0.35	0.30	0.40	1.7	3.8	0.30	0.001	0.001	0.001	0.001	0.001	0.015	0.010	Rem.

All Weld Metal Mechanical Properties

Hardness (as welded)
~48 HRC

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	ISO 14175 : I1 (Ar) 6-12 L/min

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FT En-TR02-200408

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