



## TIG HB25

Old reference: TIG R250B

### Classification

EN 14700 : S Fe1

Material N° : 1.8401

### Description & Applications

Copper coated solid rod for TIG hardfacing of low alloys steels and casting. Tough deposit, easy to machine.

**Main applications:** For surfacing of rails, shafts, rollers, crane wheels as well as for semi-hard build up and intermediate layers.

### Typical Chemical Composition ( % )

	C	Si	Mn	Cr	Ni	Mo	W	V	Ti	P	S	Fe
Min												
Max	0.4		4.5	3.5	3	1	1	1				Rem.
Type	0.25	0.50	1.0	1.0	0.01	0.05	0.01	0.005	0.20	0.015	0.005	Rem.

### All Weld Metal Mechanical Properties

Hardness (as welded)  
225-275 HB

### Welding Current & Instructions

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

FT En-TR11-200408

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