



## TIG HB35

Old reference: TIG R350B

### Classification

EN 14700 : S Fe2

### Description & Applications

Copper coated solid rod for TIG hardfacing of construction or cast steels. Good wear resistance under pressure combined to shocks.

**Main applications:** Hardfacing of pressing and stamping tools.

### Typical Chemical Composition ( % )

	C	Si	Mn	Cr	Ni	Mo	Cu
Min	0.4						
Max	1.5		3	7	4	1	1
Type	0.07	0.40	0.50	5.8	0.05	0.60	0.10
	W	Ti	V	Co	P	S	Fe
Min							
Max	1		1	1			Rem.
Type	0.01	0.005	0.01	0.005	0.015	0.010	Rem.

### All Weld Metal Mechanical Properties

Hardness (as welded)

35 HRC

### Welding Current & Instructions

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

Preheat the parent metal, depending on the carbon-equivalent and thickness, up to 300-400°C.

FT En-TR12-200408

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