



TIG HB50

Old reference: TIG R500B

Classification

EN 14700 : S Fe2

Description & Applications

Copper coated solid rod for TIG hardfacing of construction steels or Mn steels. Excellent wear resistance.

Main applications: Hardfacing of civil engineering equipments such as shovel and bucket teeth, bucket edges, excavators as well as cutting edges.

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu
Min	0.4						
Max	1.5		3	7	4	1	1
Type	1.1	0.45	1.9	1.8	0.05	0.01	0.05
	W	Ti	V	Co	P	S	Fe
Min							
Max	1		1	1			Rem.
Type	0.01	0.20	0.01	0.005	0.015	0.010	Rem.

All Weld Metal Mechanical Properties

Hardness (as welded)
47-52 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.
DO NOT PREHEAT MN STEELS!

FT En-TR13-200408

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