



## TIG HBC62

Old reference: TIG F820D

### Classification

EN 14700 : S Fe4

Material N° : 1.3348

### Description & Applications

Solid rod for TIG hardfacing and repairing of high speed steels like 85WMoCrV6.5.4.2, 1.3339, 1.3333 and others.

**Main applications:** For hardsurfacing cold working tools as lathe tools, drilling tools, cutting tools.

### 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	1.0	0.40	0.30	3.6	0.001	8.7	1.7	1.85	0.001	0.001	0.02	0.01	Rem.

### All Weld Metal Mechanical Properties

Hardness (as welded)  
~62 HRC

### Welding Current & Instructions

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

Tool steels have to be preheated to 350-450°C, depending on the thickness and composition.

FT En-TR16-200408

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