



TIG MV5S*

Classification

EN 14700 : S Fe4

DIN 8555 : WSG 3-GZ-60-P

Description & Applications

Solid rod for TIG welding and hardfacing of low alloyed steels with similar chemical composition like X50CrMoWV5. Good resistance against shocks and metal/metal wear with service temperatures up to 550°C. Product of high purity for welding without microporosity.

Main applications: Moulds for plastic injections, cold or hot working tools, shredder hammers.

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	0.50	0.90	0.40	5.0	0.001	1.3	1.3	0.40	0.001	0.001	0.010	0.002	Rem.

All Weld Metal Mechanical Properties

Hardness (as welded)
60 HRC

Welding Current & Instructions

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

Pre-heating of massive parts at 300-400°C. Maintain temperature during welding and cold slowly, preferentially in oven, to limit cracks during cooling.

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