HARDCOR 50 G

Standards

TS EN 14700	: T Z Fe 8
EN 14700	: T Z Fe 8
DIN 8555	: MF 3-50-CKTZW

Chemical Composition of Weld Metal % (Typical)

C	Si	Mn	Cr	Ni	Mo	Co	Fe
0.1	0.7	0.4	15.0	+	3.2	14	Rest

Mechanical Properties

Hardness	
(As Welded) (HRC)	(After Working) (HRC)
48 - 50	53

Typical Base Material Grades

- Hardfacing of hot- work tool steels, forging dies, hot-shearing tools, punch tools, punch tools, rollers, hot hardening treatment, steel mili rolls Continuous casting driving rolls, dies, mandrels, forming tools, pumps

Features and Applications

- Applicability in hardfacing for protection against wear of steels working at temperature sup to 650°C
- Existence of high amounts of Cr, Co, Mo alloys in weld metal
- High resistance to cracking
- Oxidation-and creep resistant behaviours at high temperatures
- High resistance againist sliding wearof metallic object
- High resistance to thermal shock
- Shielding Gas: M 13 (Ar+1%O_2)

Welding Positions

Operating Data

Diameter (mm)	Welding Current (A)	Voltage (V)	Stick-out (mm)
1.20	170 - 200	27 - 30	15 - 25

Current Type

FCAW / D.C. (+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
6031100370	1.20	0.047”	15

Approvals: GOST-R, CE, SEPRO