

Standards

TS EN 14700	: E Fe 1
EN 14700	: E Fe 1
DIN 8555	: E 3-UM-400-GPTS

**Chemical Composition of
Weld Metal % (Typical)**

C	Mn	Si	Mo	V	Cr	W
0.2	1.1	0.8	0.6	0.4	3.2	0.5

Mechanical Properties

Hardness (HB)
380 - 440

Features and Applications

- Used in surface coating applications and dies made from hot work tool steels.
- According to the base material pre-heat and slow cooling can be done
- Weld metal keep its hardness until 500°C
- Re-drying: 300°C - 350°C / 2h

Resistance Type and Level

Friction



Impact



High Temp.



Thermo Shock



Corrosive



Crack Resistance



Machining


Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101906	3.20 x 350	1/8 x 14"	100 - 140	3700
3010101909	4.00 x 350	5/32 x 14"	140 - 180	5390

Approvals: SEPRO