

### Standards

DIN 8555 : MSG 1-GZ-250

### Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr	Mo
0.09	0.55	1.00	3.00	1.00

### Mechanical Properties

**Hardness** (after working)  
(HRC)

22 - 27

### Features and Applications

- Cr-Mo alloyed steels (1.5%-0.5%) resistant to high temperature, wear, pressure and shocks
- Good resistance to cracking and to the attack of sulphures agents
- Guide rollers, excavators, screw conveyers, gears, moulds, rolling surfaces, etc
- Before the application of welding, it is recommended pre-heating of 300°C
- If necessary, post- weld stress relief should be made at 690°C
- Shielding Gas: Ar+CO<sub>2</sub> mix gases can be used

### Resistance Type and Level

Friction



Impact



High Temp.



Thermo Shock



Corrosive



Crack Resistance



Machining



### Current Type

MAG D.C.(+)

### Operating Data

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
6031100313	1.20	0.047"	15	BS 300 Spool

Approvals: SEPRO