

### Standards

EN 14700	: S Fe 2
DIN 8555	: MSG / WSG 2-GZ-50

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

C	Si	Mn	Cr	Ti
1.10	0.50	1.90	1.80	0.20

### Mechanical Properties

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

47 - 52

### Features and Applications

- Excellent resistance to wear and shocks
- Parts of excavators, mordan bucket theeth, drilling and percussion bits, shaping machines, screw conveyors, crushers, moulds, guide rollers, etc
- Before the application of welding, it is recommended pre-heating of 300°C
- It necessary, post- weld stress relief should be made at 690°C
- Shielding Gas: MAG; Ar+CO<sub>2</sub> mix gases & TIG; % 100 Ar gas can be used

### Resistance Type and Level

Friction



Impact



High Temp.



Thermo Shock



Corrosive



Crack Resistance



Machining



### Current Type

MAG D.C.(+) / TIG D.C. (-)

### Operating Data

Product Code	Diameter x Length		Weight (Kg)	Package Type
	(mm)	(inch)		
6031100315	1.20	0.047"	15	BS 300 Spool
6031100316	2.00 x 1000	5/64 x 39"	5	Carton Box

Approvals: SEPRO