

**Standards**

TS EN 14700	: S Fe8
EN 14700	: S Fe8
DIN 8555	: MSG G GZ 60

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

C	Mn	Cr	Si
0.45	0.040	9.20	3.0

**Mechanical Properties**

Hardness			
(After Working)	Softening (800°C)	1000°C - Oil	Single Pass in Unalloyed Steel
55-60 HRC	~250 HB	62 HRC	~53 HRC

**Features and Applications**

- It is used in welding of alloyed and non alloyed metal parts of mining and earth machines, pulsed run drilling and crushing machines
- Build up cutting tool edges and hard manganese steels cover pass
- It can be machined by grinding
- Shielding gas: MAG; Ar+CO<sub>2</sub> mix gases and TIG; %100 Ar gas can be used

**Resistance Type and Level**

Friction



Impact



High Temp.



Thermo Shock



Corrosive



Crack Resistance



Machining


**Welding Electrode**

GeKaTec FAZER 55 HD

**Current Type**

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

**Operating Data**

Product Code	Diameter x Length		Package Weight (Kg)
	(mm)	(inch)	
6031100317	1.00	0.040"	15
6031100318	1.20	0.047"	15
6031100319	2.00 x 1000	5/64 x 39"	5
6031100320	2.40 x 1000	3/32 x 39"	5

Approvals: SEPRO