

Standards

TS EN 14700	: T Fe 6
EN 14700	: T Fe 6
DIN 8555	: MF 6 GF 60 GR

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

C	Si	Mn	Cr	Mo	Nb
0.60	0.60	0.65	8.2	0.2	0.15

Mechanical Properties

Hardness (as welded) (HRC)
56

Typical Base Material Grades

- Hardfacing of parts of earth and mineral mining machines, impactdrilling and crushing devices, guide springs, edges of cutting tools, hard bucket edges and teeth, all of which are made of alloyed or unalloyed steels, as well as in order materials required to have high resistance to wear, debraking knives, agricultural tillage tools, earth moving bucket lips

Features and Applications

- Used in hardfacing welding of pieces exposed to high impact and abrasion wear
- Weld metal microstructure is martensitic and has excellent resistance to friction metal to metal
- This wire can also be used as a filling for cutting edge welding
- Cracking does not observed
- Because of the rutile character there is no spatter during welding, weld metal seam is perfect
- Shielding Gas: CO₂

Resistance Type and Level

Friction	High Temp.	Corrosive	Machining
■■■■■	■■■■■□	■■□□□	■■■■■□
Impact	Thermo Shock	Crack Resistance	
■■■■■	■■■■■□	■■■■■□	

Operating Data

Diameter (mm)	Welding Current (A)	Voltage (V)	Stick-out (mm)
1.20	170 - 200	27.0 - 30.0	25.0 - 30.0
1.60	180 - 220	26.0 - 31.0	25.0 - 30.0

Current Type

FCAW / D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
3030500018	1.20	0.047"	15
3030500019	1.60	0.062"	15

Approvals: SEPRO