

## Standards

TS EN 14700	: T Z Fe 3
EN 14700	: T Z Fe 3
DIN 8555	: MF 3-GF-40-ST

## Chemical Composition of Weld Metal (Typical)

C	Mn	Cr	W	V
0,16	0,25	3,0	4,50	0,40

## Mechanical Properties

Hardness
(As Welded) (HRC)
39-41

## Features and Applications

- Metal type flux-cored wire. Machinability is very good.
- It has a special alloy designed for the repair and hard surface coating of tools operating at low and high temperatures.
- HARDCOR KST 45 is suitable for claddings on high stressed hot working tools subject to compression, impact and abrasion at elevated temperatures, such as forging dies, female dies, stamps, die cast moulds, guidings, rollers.
- It's can be welded on non and low alloyed base materials.
- Shielding gas: M21

## 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	150 - 220	26 - 30	20 - 25

## Current Type

D.C. (+)

## Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
3030500398	1.20	0.047"	15