

Standards

TS EN 14700	: T Z Fe 3
EN 14700	: T Z Fe 3
DIN 8555	: MF 3-GF-55-ST

Chemical Composition of Weld Metal (Typical)

C	Mn	Cr	W	V
0,30	0,28	3,8	4,5	0,40

Mechanical Properties

Hardness

(As Welded) (HRC)

52-57

Features and Applications

- Metal type flux-cored wire. Used for repairing hot and cold work tools. Machinability is very good.
- HARDCOR KST 55 is a metal type flux-cored wire which wear resistant alloy and can be applied to reclaim hot-forging dies.
- It can be applied to overlay the edges and flat areas of low alloyed high density steel tools.
- It is used in the repair of equipment that is subject to high wear such as buckets, excavators, crushers used in the mining industry.
- Shielding Gas: M21

Resistance Type and Level

Friction



Impact



High Temp.



Thermo Shock



Corrosive



Crack Resistance



Machining



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		Package Weight (Kg)
	(mm)	(inch)	
3030500410	1.20	0.047"	15