

**Standards**

DIN 8555	: MSG 3-GZ-50-ST
	: WSG 3-GZ-50-ST

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

C	Si	Mn	Cr	Ti	Mo
0.30	0.50	0.70	5.00	0.70	3.60

**Mechanical Properties**

<b>Hardness (as welded)</b> (HRC)
45 - 48

**Typical Base Material Grades**

- 1.2367-1.2365-1.274-1.2344-1.2343-1.2083

**Features and Applications**

- Generally are used in build-up for hot work tool steels
- Application areas forging dies, gravures, hot cutting tools, de-burring tools, punches, aluminum casting moulds, repair of 1.2344 hot work tool steels
- Used in steel casting and mold applications with 45-48 HRC strength of hardfacing welds
- Weld metal has wear and impact resistance at high temperatures
- 400°C pre-heat must be done before welding
- It has wear and impact resistance at high temperatures
- Shielding gas: MAG: Ar+CO<sub>2</sub>

TIG: Ar

**Resistance Type and Level**

Friction	High Temp.	Corrosive	Machining
			
Impact	Thermo Shock	Crack Resistance	
			

**Welding Electrode**

GeKaTec THERMO DUR

**Current Type**

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

**Operating Data**

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)	
			MAG	TIG
6031100143	1.00	0.040"	BS 300 15 Kg	Carton Box 5 Kg
6031100329	1.20	0.047"		
6031100330	1.6 x 1000	1/16 x 39"		
6031100331	2.0 x 1000	5/64 x 39"		
6031100332	2.4 x 1000	3/32 x 39"		

Approvals: SEPRO