

Standards

DIN 8555	: MSG 3-GZ-55-T
	: WSG 3-GZ-55-T

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr	Mo
0.35	0.40	1.00	7.00	1.10

Mechanical Properties

Hardness (as welded) (HRC)
53 -58


Typical Base Material Grades

- 1.2510-1.2363-1.2721-1.2379-1.2842-1.1730-1.2990

Features and Applications

- Application areas are cold and hot work tool steels which are used in machine parts, cold and hot cutting blades, extrusion dies, rollers, steel castings and moulds
- It is hard facing wire which has high abrasion resistance and keep hardness at high temperatures
- 400°C pre-heat temperature must be done before welding if it is needed, stress relieving must be done at 550°C after welding
- Shielding gas: MAG: Ar+CO₂
TIG: Ar

Resistance Type and Level

Friction	High Temp.	Corrosive	Machining
			
Impact	Thermo Shock	Crack Resistance	
			

Welding Electrode

GeKaTec TOOL 58 S

Current Type

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

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)	
			MAG	TIG
6031100148	1.00	0.040"	BS 300 15 Kg	Carton Box 5 Kg
6031100333	1.20	0.047"		
6031100334	1.6 x 1000	1/16 x 39"		
6031100389	2.0 x 1000	5/64 x 39"		
6031100335	2.4 x 1000	3/32 x 39"		

Approvals: SEPRO