

Standards

TS EN 14700	: E Fe 4
EN 14700	: E Fe 4
AWS A5.13	: E Fe 5-A
DIN 8555	: E 4-UM-60 S

Mechanical Properties

Hardness (after working) (HRC)
60 - 62

Features and Applications

- The weld deposit is the similar to the high speed steel so it is used for reconditioning the surface and cutting edges of hot working tool steels and tools made from unalloyed steels.
- Main applications are the tools exposed to heat, adhesion and impact wears
- It is recommended that preheating to 400°C before the welding of high carbon steels and tool steels
- Re-dry for 2 hours at 300°C - 350°C

Resistance Type and Level

Friction



Impact



High Temp.



Thermo Shock



Corrosive



Crack Resistance



Machining



MIG Wire

GeKaTec TOOL 60 SG

Current Type

D.C.(+) / AC

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Package Weight (Kg)	Weight g / 100 pcs
3030100086	3.20 x 350	1/8 x 14"	90 - 120	5	3290

Approvals: SEPRO