

Standards

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|-------------|-----------------|
| TS EN 14700 | : T Fe4 |
| EN 14700 | : T Fe4 |
| DIN 8555 | : TIG 3-GF-60-T |

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

| C | Si | Mn | Cr | Mo | W |
|------|-----|-----|-----|-----|------|
| 0.55 | 0.5 | 0.4 | 4.0 | 8.0 | 1.60 |

Mechanical Properties

| |
|---------------------------------------|
| Hardness (as welded) (HRC) |
| 56 - 60 |

Features and Applications

- It is hardfacing TIG wire which has high abrasion resistance and keep hardness at high temperatures
- Application range is cold and hot work tool steels which are used in machine parts, cold and hot cutting blades, extrusion dies, rollers, steel casings, moulds, tools and metal-to-metal friction applications
- Weld metal is machinable by grinding
- It is recommended that pre-heating at 400°C before welding and very slow cooling after welding
- If necessary, it is recommended the stress relief annealing at 550°C after welding
- Shielding Gas: Argon

Resistance Type and Level

| | | | |
|--------------------|-----------------------|----------------------------|---------------------|
| Friction ■■■■■□ | High Temp. ■■■■■ | Corrosive ■■■■□□ | Machining ■■■■□□ |
| Impact ■■■■■□ | Thermo Shock ■■■■■ | Crack Resistance ■■■■■□ | |

Current Type

TIG D.C. (-)

Operating Data

| Product Code | Diameter x Length (mm) / (inch) | Package Weight (Kg) | Package Type |
|--------------|------------------------------------|------------------------|--------------|
| 3030600002 | 2.40 x 1000 / 3/32 x 39" | 5 | Carton Box |

Approvals: SEPRO