

Standards

DIN 8555 : M / WSG 4-60-S

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

C	Si	Mn	Cr	Mo	V	W
1.0	0.3	0.3	4.0	8.3	1.9	1.8

Mechanical Properties
Hardness (after welding)
(HRC)

60 - 62

Typical Base Material Grades

- 1.2436-1.3241-1.3344-1.3207

Features and Applications

- Application range is production of cutting edges of mild steels, hardfacing of cutting edges of cutting dies
- It is hard facing wire
- Weld metal structure is similar to high speed steel and has abrasion, wear and pressure resistance
- Shielding gas: TIG: Ar

Resistance Type and Level

Friction



Impact



High Temp.



Thermo Shock



Corrosive



Crack Resistance



Machining


Welding Electrode

GeKaTec TOOL 60

Current Type

TIG D.C.(-)

Operating Data

Product Code	Diameter x Length		Package Weight (Kg)
	(mm)	(inch)	
6031100336	1.6 x 1000	1/16 x 39"	5
6031100337	2.0 x 1000	5/64 x 39"	5
6031100338	2.4 x 1000	3/32 x 39"	5

Approvals: SEPRO