


Technical data sheet <small>011121MBA</small>	Cored welding wire ROBOTOOL 49W-G	
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CLASSIFICATION

EN 14700: T ZFe8

DESCRIPTION

- Seamless high fill copper coated tubular wire for semi-automatic gas shielded hardfacing
- Unique welder appeal
- Deposition rate increased by up to 20% when compared to solid wire
- Strong and tough hot working steel type deposit for service temperatures up to 550°C
- Wire does not pick up moisture, the wire feeding properties are excellent
- Designed for welding in horizontal, horizontal-vertical and vertical-up positions

APPLICATIONS

Hardfacing parts undergoing metal-to-metal wear, compression and moderate impact loads at high temperatures

Examples:

Hot shear blades, hot and cold punching tools, extrusion press pistons, forging and trimming tools etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	W	V	Ti
0.28	0.70	0.50	5.50	2.50	2.10	0.70	0.15

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: As welded, 3-layer deposit on mild steel: 49 HRc
 After PWHT 520°C / 10hrs: 50 HRc

CONDITIONS OF USE

Current type	Shielding gas	
DC+	EN ISO 14175	M12: Ar + 0.5 – 5 % CO ₂
		M13: Ar + 0.5 - 3% O ₂
		M21: Ar + 15 – 25 % CO ₂

OPERATING CONDITIONS

Diameter [mm]	Intensity [A]	Voltage [V]	Stick-out	Gas flow rate
1.2	110 - 300	16 - 32	12 -18 mm	10 - 20 l/min.
1.6	130 - 350	16 - 32	12 -18 mm	10 - 20 l/min.

Recovery: 98 %

WELDING POSITIONS

ROBOTOOL 49W-G is suitable as well for downhand as for positional welding by adapting transfer mode and welding parameters as for solid wires.

PACKAGING

Diameter	1.2 mm	1.6 mm
	EN ISO 544 – ASME II C SFA-5.2 M	
Spool type	BS300	
Weight	15 kg	

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.