

**Technical data sheet**

011121MBA

Cored welding wire

**HARDFACE R58-G****CLASSIFICATION**

EN 14700: T ZFe3

**DESCRIPTION**

- Metal cored wire for gas shielded metal arc hardfacing
- Strong and tough hot working steel type deposit for service temperatures up to 550°C
- Wire does not pick up moisture, wire feeding properties are excellent
- Designed for welding in horizontal, horizontal-vertical and vertical-up positions

**APPLICATIONS**

Hardfacing and local repairs on 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	Ti
0.35	1.20	0.50	7.00	2.20	0.30

**TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES**

Hardness:

As welded, 3-Layer deposit on mild steel; 55 HRc

**SHIELDING GAS**

EN ISO 14175	M12	Ar + 2 - 5% CO <sub>2</sub>
	M21	Ar + 15 - 25% CO <sub>2</sub>
	M20	Ar + 5 - ≤ 15% CO <sub>2</sub>
	M13	Ar + 2 - 3% O <sub>2</sub>

**OPERATING CONDITIONS**

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]	Gas flow rate [l/min]
1.2	DC+	110 - 300	16 - 32	12 - 25 mm	10 - 20 l/min.
1.6	DC+	130 - 350	16 - 32	12 - 25 mm	10 - 20 l/min.

Recovery: 98 %

**WELDING POSITIONS**

HARDFACE R58-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	S200	BS300	BS300
Weight	5 kg	15 kg	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.