

Technical data sheet <small>EN020524GB</small>	Cored welding Wire HARDFACE 50W-G	
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CLASSIFICATION

EN 14700: T Fe3

DESCRIPTION

- Cored wire for gas shielded arc welding
- Martensitic alloyed steel compatible with AISI H11, H12, and overalloying the H13 tool steel
- The high content of tungsten, vanadium, molybdenum, and chromium makes this wire highly resistant to temperature and thermal fatigue when subjected to heating and cooling cycles
- Withstands high temperatures without softening, allowing consistent wear resistance

APPLICATIONS

HARDFACE 50W-G is used for rebuilding shallow impressions, hot and cold trim dies, shearing dies, extrusion dies, plastic injection moulds, punches, ect.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	V	W	Fe
0.30	0.8	0.8	6.8	2.0	0.6	2.0	Bal.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness:

As welded, 3-layer on mild steel: 50 - 53 HRC

Tensile:

Ultimate Tensile Strength: 1650 MPa

CONDITIONS OF USE

Current type	Gas-shielding
DC (+)	M21: Ar + 15 - 25 % CO ₂
	M20: Ar + 5 - 15% CO ₂
	M12: Ar + 2 - 5 % CO ₂
	C1: CO ₂

OPERATING CONDITIONS

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	100 - 300	220	20 - 30	26	15 - 25	20
1.6	150 - 350	270	25 - 35	27	20 - 30	25
2.0	200 - 400	300	25 - 35	28	20 - 30	25
2.4	250 - 450	350	25 - 35	28	20 - 30	25

Recovery: 95 %

WELDING POSITIONS

Flat

PACKAGING

Diameter	1.2 - 2.4 mm	2.4 mm	
Standard packaging (EN ISO 544)	BS 300 spool	B 450 coil	Drum
Weight	15 kg	25 kg	Up to 330 kg

Other packaging: 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.