

<b>Technical data sheet</b>  <small>EN020524GB</small>	<b>Cored welding Wire</b> <b>HARDFACE 55Cr-G</b>	
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### CLASSIFICATION

EN 14700: T Fe3

### DESCRIPTION

- Metal cored wire for gas shielded arc welding
- Martensitic alloyed steel deposit offering high strength and outstanding resistance to hot oxidation due to high chromium content
- The addition of vanadium and tungsten enhances the resistance to heat checking
- The welding deposit is advantageous for intricate impressions where toughness is required

### APPLICATIONS

HARDFACE 55Cr-G is used for rebuilding shallow hammer dies, press dies, ect.

### TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	V	W	Fe
0.35	0.5	0.4	8.0	2.0	2.3	0.3	0.3	Bal.

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

#### Hardness:

As welded, 3-layer on mild steel: 50 - 55 HRC

#### Tensile:

Ultimate Tensile Strength: 1650 MPa

### CONDITIONS OF USE

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

### 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.