


Technical data sheet <small>EN020524GB</small>	Cored welding Wire HARDFACE 60Mo-G	
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CLASSIFICATION

EN 14700: T Fe4

DESCRIPTION

- Metal cored wire for gas shielded arc welding
- Martensitic alloyed steel deposit giving a near-matching AISI M2 high-speed tool steel
- The welding deposit maintains high hardness even at high temperatures
- Remains hard, giving excellent properties on cutting edges, draw beads, and radii

APPLICATIONS

HARDFACE 60Mo-G is used for rebuilding draw dies, shear blades, stamping dies, ect.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	V	W	Fe
1.1	0.5	0.5	5.0	7.4	1.1	2.3	Bal.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness:

As welded, 3-layer on mild steel: 57 - 63 HRC

Tensile:

Ultimate Tensile Strength: 1950 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.