

## Classifications

|          |               |              |
|----------|---------------|--------------|
| EN 14700 | DIN 8555      | Material-No. |
| S Fe 8   | MSG 6-GZ-60-S | 1.4718       |

## Characteristics and field of use

WEARmig Dur 600 is universally applicable for MAG buildups on structural parts subject to high impact and medium abrasion. Main applications are found in quarries, crushing plants, mines, steel works, cement works as well as cutting tools and dies in the car industry. Despite the high hardness, the deposit is very tough, crack resistant and has an excellent cutting behaviour.

Despite the high hardness, the weld deposit of WEARmig Dur 600 is tough, crack resistant and has a good cutting capacity. Machining by grinding possible.

Hardness of the pure weld deposit

|                              |                |
|------------------------------|----------------|
| untreated                    | 54 – 60 HRC    |
| soft annealed 800° C         | approx. 250 HB |
| hardened 1000° C/oil         | approx. 62 HRC |
| 1 layer on non-alloyed steel | approx. 53 HRC |

## Typical analysis in %

|     |     |     |     |         |
|-----|-----|-----|-----|---------|
| C   | Si  | Mn  | Cr  | Fe      |
| 0.5 | 3.0 | 0.5 | 9.5 | balance |

## Welding instruction

Grind the welding area to metallic bright. Generally, only tool steels have to be preheated to 450 °C.

## Approval

-

| Wire diameter [mm] | Current type | Shielding gas (EN ISO 14175) |      |      |     |
|--------------------|--------------|------------------------------|------|------|-----|
| 0.8                | DC (+)       | M 12                         | M 13 | M 21 | C 1 |
| 1.0                | DC (+)       | M 12                         | M 13 | M 21 | C 1 |
| 1.2                | DC (+)       | M 12                         | M 13 | M 21 | C 1 |
| 1.6                | DC (+)       | M 12                         | M 13 | M 21 | C 1 |