

## Classifications

DIN 8555	EN 14700
MSG 6-GT-60-GP	T Fe 8

## Characteristics and field of use

Seamless, Chromium alloyed, metalcored wire for wear resistant surfacing applications with Ar-CO<sub>2</sub> shielding gas. This wire is well indicated for the coating of ceramic tiles. Features include: better arc stability and less noise if compared to similar solid wires, good resistance to abrasion and good weldability on new or restored tiles. Low amount of slag also after several welding beads, the residual slag can be easily removed.

Main applications are coating of new and restored ceramic tiles, parts of earth moving machinery, rollers, mills and supports.

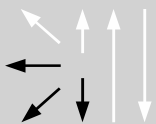
Hardness as welded: 57 - 62 HRC

Flow rate: 14 - 20 l/min

## Typical analysis in %

C	Mn	Si	P	S	Cr
0,45	0,4	3,0	< 0,025	< 0,025	9,0

## Welding positions



Current type DC (+)  
Shielding gas: Argon / CO<sub>2</sub> (EN ISO 14175: M21)

## Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]
1,0	40-270	11-32
1,2	50-320	12-35
1,4	50-380	14-36
1,6	60-420	16-38
2,0	100-450	17-40
2,4	150-500	18-42