



MIG-wires / TIG-rods
MASTERWELD HARDTOOL 6-SG

Technical standard:

DIN 8555 : MSG 4-GZ-60-S/ WSG 4-GZ-60-S
 Grade-Nr : 1.3348
 AWS (AISI J 438 b) : M 7

Specification:

copper-coated drawn

Range of application/properties:

For repairing and manufacturing tools of high-speed-steel, for hard-facing of Mo-alloyed steels, weld metal without soft annealing, only workability by grinding, for example for cutting tools, gouges, turning tools, broaches a.s.o.

Chemical composition: (Standard values / Wire analysis in %)

C	Si	Mn	Cr	Mo	V	W
1,00	0,30	0,30	4,00	8,30	1,90	1,80

Chemical composition of pure weld metal is depending from the applied welding parameters

Mechanical Properties: (Weld metal, untreated)

Welding-process	Rm (N/mm ²)	Rpo, 2 (N/mm ²)	A5 (%)	Range of hardness DIN 8555/T.1 (HRC)
MIG, TIG	-	-	-	57 - 62

Welding parameters:

Inert gas acc. DIN EN 439

Process	Inert gas	Process	Inert gas
MIG	M 21	TIG	I 1 / pure Argon

<p>type of current</p> <p>MIG-Wire: Direct current (+ Pole)</p> <p>TIG-rods: Direct current (- Pole)</p>	<p>welding positons</p> <p>w h s q hü ü f</p> <p>w h s q hü ü</p>
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Diameters: ø (mm)_

MIG-wires	1,00	1,20	1,60			
TIG / l = 1000 mm	1,00	1,20	1,60	2,00	2,40	3, 20

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