

**Standards :**

TS EN 14700	:	S Fe 8
EN 14700	:	S Fe 8
DIN 8555	:	MSG 6 GZ 60

**Chemical Composition of Welding Wire-  
% (Typical) :**

C	Mn	Cr	Si
0.45	0.040	9.20	3.0

**Mechanical Properties :**

Hardness			
As Welded	Softening (800°C)	1000°C - Oil	Single Pass in unalloyed steel
55 - 60 HRC	~250 HB	62 HRC	~53 HRC

**Features and Applications :**

- \* It is used in welding of alloyed and non alloyed metal parts of mining and earth machines, pulsed run drilling and crushing machines.
- \* Build up cutting tool edges and hard manganese steels cover pass.
- \* It can be machined by grinding.
- \* Shielding gas : MAG; Ar+CO<sub>2</sub> mix gases and TIG; %100 Ar gas can be used.

**Welding Positions :**

**Current Type :**

MAG D.C. (+)  
TIG D.C. (-)

**Welding Electrode :**

GeKaTec FAZER 55 HD

**Operating Data :**

Diameter (mm)	Diameter (inch)	Welding Current (A)	Voltage (V)	Package Weight(kg)	Package Type
1.00	0.040"	135 - 260	26 - 31	15	B 300 (K300) Spool
1.20	0.047"				
2.00 x 1.000	5/64 x 39"				
2.40 x 1.000	3/32 x 39"				

**Approvals :**

GOST-R, SEPRO, CE