

Standards :

| | | |
|----------|---|------------|
| DIN 8555 | : | MSG 3-40-T |
| | : | WSG 3-40-T |

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

| | | | | | |
|------|-----|-----|-----|-----|-----|
| C | Si | Cr | Mo | Mn | Ti |
| 0.20 | 0.3 | 5.2 | 3.5 | 0.6 | 0.7 |

Mechanical Properties :

| |
|-------------------------------|
| Hardness (as welded) (HRC) |
| 37 - 42 |

Features and Applications :

- * Used in build up materials exposed to impact, pressure and abrasion, hot work tool steels.
- * Application range is forging dies, hammers, v-beds, cast steels, continuous casting rollers.
- * It has wear resistance and high toughness at high temperatures.
- * Shielding gas : MAG : Ar+CO₂
TIG : Ar

Welding Positions :

Current Type :

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

Welding Electrode :

~GeKaTec THERMO RESIST

Operating Data :

| Diameter x Length (mm) | Diameter x Length (inch) | Welding Current (A) | Voltage (V) | Package Type | |
|---------------------------|-----------------------------|------------------------|----------------|--------------|------------|
| | | | | MAG | TIG |
| 1.00 | 0.40" | --- | --- | | |
| 1.20 | 0.047" | 135-260 | 26-31 | B 300 | Carton Box |
| 1.6 x 1000 | 1/16 x 39" | --- | --- | 15 Kg | 5 Kg |
| 2.0 x 1000 | 5/64 x 39" | --- | --- | | |
| 2.4 x 1000 | 3/32 x 39" | --- | --- | | |

TIG Rods : \varnothing 1.6/ 2.0 / 2.4 x 1000 mm

Approvals :

GOST-R, SEPRO