

Standards :

DIN 8555 : M/WSG 4-60-S

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

C	Si	Mn	Cr	Mo	V	W
1.0	0.3	0.3	4.0	8.3	1.9	1.8

Mechanical Properties :

Hardness (as welded)
(HRC)

60 - 62

Features and Applications :

- * Application range is production of cutting edges of mild steels, hard facing of cutting edges of cutting dies.
- * It is hard facing wire.
- * Weld metal structure is similar to high speed steel and has abrasion, wear and pressure resistance.
- * Shielding gas : MAG : Ar + CO₂
TIG : Ar

Welding Positions :



Current Type :

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

Welding Electrode :

GeKaTec TOOL 60

Operating Data :

Diameter x Length (mm)	Diameter x Length (inch)	Welding Current (A)	Voltage (V)	Package Weight(kg)
1.20	0.047"	135-260	26-31	15
1.6 x 1000	1/16 x 39"	---	---	5
2.0 x 1000	5/64 x 39"	---	---	5
2.4 x 1000	3/32 x 39"	---	---	5

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

Approvals :

GOST-R, SEPRO