

## Classifications

EN 14700	Material-No.
S Fe 8	1.4718

## Characteristics and field of use

Copper coated solid wire electrode for MIG/MAG-welding of wear resistant hard-surfacing on conveyor-rollers, rock-bits, cutting edges of excavator shovels, etc. The wire can be welded using mixed gases or carbon dioxide as shielding gas. The weld metal is resistant against wear and mechanical impact.

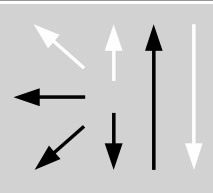
Hardness of the weld metal: 57-62 HRC

C	Si	Mn	Cr	Fe
0.45	3.0	0.4	9.0	balance

## Welding instruction

Pay attention to the welding behavior of the parent material! If necessary buffer the material with poor weldability (carbon steel, heat treatable steels) with a single or several layers of UTP 63.

## Welding positions



## Approvals

DB

Wire diameter [mm]	Current type	Shielding gas (EN ISO 14175)			
1.0	DC (+)	M 12	M 13	M 21	C 1
1.2	DC (+)	M 12	M 13	M 21	C 1