## S-G 600 T-G 600

## International standards

	S = solid wire	T = bare rod				
Mat. No.	1.4718					
DIN 8555	MSG 6-GZ-60-S	WSG 6-GZ-60-S				

## **Application notes**

Solid wire for rebuilding of machine parts subject to combined wear from abrasion and impact. Suitable for deposits on mild steel, steel castings and manganese steel.

The pure weld deposit is only machinable by grinding.

On high-carbon and crack-sensitive base materials, should be preheated to 200° – 300° C, depending on their composition and thickness.

## **Typical applications**

Rollers, dredger chains, conveyors, hammers, dredger equipment, mining and earth-moving equipment

Hardness of all-weld metal (typical values)

as welded	Soft annealed 5 h	Hardened oil - air cooling				
59 HRc	780°C – 820° C	1000°C – 1050°C				

Weld metal analysis (typical, wt %)

С	Si	Mn	Cr		
0,5	3,0	0,5	9		

Gas types EN 439

S = solid wire	T = bare rod
M2, M3, C1	I1

Current

Current	= +				= -					
Diameter	mm	0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0
Welding amps	(A) min.	80	120	180	250					
3 - 1 -	(A) max.	130	190	250	320					

coils, weight

Rev. 001/13

B300 15 kg.

10 kg.

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Manufactor may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.