

# 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 %)

C	Si	Mn	Cr
0,5	3,0	0,5	9

## Gas types EN 439

S = solid wire

M2, M3, C1

T = bare rod

I1

## 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					
(A) max.	130	190	250	320					

## coils, weight

B300 15 kg.

10 kg.

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