Hardfacing Solid Mig Wires | Inefil 600 BR

Key Facts

- Extends the operation life of many wearing parts
- Excellent abrasion resistance to moderate impact
- Deposits weld metal of high toughness
- Hard facing electrode 54HRC single layer, 58HRC multiple layers

Description

Bronze-coated solid wire mostly used with semiautomatic and automatic procedures, for hard-facing wheels, rolling mill rollers tracks, sliding rollers, screws, mill crushing jaws and mill wheels, where excellent resistance to abrasion is required especially when accompanied by shocks, and blows, and for hard-facing wearing components such as excavation buckets and teeth and surfaces subject to abrasion and heavy loads. A cushion layer deposited with basic-coated electrode or basic flux cored wire is essential only with hard-to-weld steels. To be used under the shield of Ar+CO2.

Precision layer wound, copper coated, hard facing MIG wire, depositing weld metal with a hardness of 54-58HRC. The weld can handle abrasion, moderate impact and metal-to-metal wear.

Classifications, Approvals & Conformances

AS/NZS 2576 1855-B5
DIN 8555 MSG6-4Z-60
WN 1.4718
EN 14700: S Fe8

Recommended Shielding Gas

Ar+CO2

Welding Positions

All positions

Applications

Ideal for use on components that are subject to high abrasion like bucket lips, screw conveyors, drilling tools, shear blades and sand dredgers.

- Suitable for facing guillotine blades, punch dies
- Hardfacing earth engaging equipment including- buckets, augers, tynes

Typical Wire Analysis

C - Carbon	Mn - Manganese	Si - Silicon	Cr - Chromium
0.43 – 0.47	0.30 – 0.60	2.80 – 3.20	8.90 – 9.50
Ni - Nickel	**Mo - Molybdenum**	**S - Sulphur**	**P - Phosphorus**
< 0.20	< 0.30	< 0.02	0.02
Cu - Copper	**Ai - Aluminium**		
< 0.20	< 0.10		

Typical Weld Mechanical Properties

Hardness:	> 54HRc

Packaging & Ordering Information

Size	Weight	Part Number
1.2mm	15kg	200385