WEARmig Tool 55

solid wire

Classifications		
EN 14700	DIN 8555	Material-No.
S Fe8	MSG 3-GZ-55-ST	Special alloy

Characteristics and field of use

WEARmig Tool 55 is used for highly wear resistant buildups on machine parts and tools, subject to heavy abrasion and compression combined with moderate impact at elevated temperatures, such as forging tools, roll mandrels, hot trimming knives, mangle and axial rolls as well as for the production of high-quality working surfaces by cladding non- or low-alloy base material.

Machinable by grinding or with tungsten carbide tools

Hardness of the pure weld deposit :

untreated	53 – 58 HRC
soft-annealed 820°C	approx. 200 HB
hardened 1050°C/oil	approx. 58 HRC
tempered 600°C	approx. 53 HRC
1 layer on non-alloyed steel	approx. 45 HRC

Typical analysis in %

C	Si	Mn	Cr	Mo	Ti	Fe
0.35	0.3	1.2	7.0	2.0	0.3	balance

Welding instruction

Clean welding area to metallic bright. Cracks in the base material have to be gouged out completely. Preheating temperature of 400°C on tools should be maintained. Stress relief/ annealing is recommended at 550°C.

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

*available on request