

Classifications

DIN 8555	EN 14700	Material-no.
WSG 6-GZ-60-S	S Fe8	1.4718

Characteristics and field of use

WEARtig Dur 600 is a TIG rod for hardfacing components which are subject to high impact and medium abrasion. Main applications are quarries, crushing plants, mines, steel works and cement works, as well as cutting tools and dies in the automotive industry.

Properties of the weld metal

Despite the high hardness, the weld deposit of WEARtig Dur 600 is tough, crack-resistant and has a good cutting capacity. Machining is possible by grinding.

Hardness of the pure weld deposit

As welded:	54 - 60 HRC
Soft-annealed 800°C:	approx. 250 HB
Hardened 1000°C/oil:	approx. 62 HRC
1 layer on non-alloyed steel:	approx. 53 HRC

Weld metal analysis in %

C	Si	Mn	Cr	Fe
0.5	3.0	0.5	9.5	balance

Welding instructions

Grind the welding area to a bright metallic finish.
Tool steels should be preheated to 250 - 450°C, depending on base metal, application and requirements.

Welding procedure and availability

Ø x length	Current type	Shielding gas (EN ISO 14175)
1.6 x 1000 mm	DC (-)	I 1
2.0 x 1000 mm	DC (-)	I 1
2.4 x 1000 mm	DC (-)	I 1
3.0 x 1000 mm	DC (-)	I 1