



730

EN 14700 T Z Fe1

DESCRIPTION

Seamless high fill copper coated tubular wire for semi-automatic gas shielded hardfacing. It is used for rebuilding of worn hardened steel parts subject to high compressive stresses and heavy impacts. It can also be used as a buffer layer on ferritic steels before hardfacing with wires providing higher abrasion resistance. Designed for welding in horizontal, horizontal-vertical and vertical-up positions. Typical applications: Transmission shafts, gear teeth, conveyor chains, wheels of rolling bridges, bearing tracks, forgings and dies etc.

WELDING POSITIONS



CURRENT

DC+
(DC-)

GAS

M21
M12

MECHANICAL PROPERTIES

Hardness

250-350 HB

WELD METAL COMPOSITION(%)

C	Si	Mn	Cr	Ni	Mo
0,14	0,4	1,1	1,6	-	0,4

PACKAGING AND WELDING PARAMETERS

Dimension(mm)	1,2	1,6		
Spolstorlek(kg)	15	15		
Current(A)	110-300	130-350		
Voltage(V)	16-32	16-32		
Stick out(mm)	12-25	12-25		
Gas flow (l/min)	10-20	10-20		

EQUIVALENT FILLER METALS

TIG	Meltolit 350 XT
MIG	Meltolit 350 XM
MMA	Meltolit 7130 E

Direct polarity (DC-) reduces dilution and favours high hardness. It can be useful in special circumstances such as hardfacing on edges.