

## QuFe10

(W.-Nr.:1.5424)

is chosen for changing and repairing shaped cavities in hardened materials  
1.2311- 1.2312 - 1.2738 - 1.2162.

The weld is suitable for shot peening=sp, hardening=ha, nitrifying=ni, etching=et,  
polishing=po, chroming=chr

Possible Hardness: 28 – 37 HRC.  
Dependent on layers and hardness of the base material

### **Recommended for basic materials:**

1.2311, 1.2312, 1.2162, 1.2738

### **Rework**

The weld can be eroded, structured, polished, chrom-plated,  
etched, nitrated, annealed and hardened.

### **Material analysis in %**

C	Si	Mo	Mn	Fe
0,1	0,6	0,5	1,1	rest

(test certificates upon request.)

### **Standard / Mechanical values**

Ø	N / mm <sup>2</sup>	elongation AL100	Items on stock	
			rods	spools
0,2	1.245	1,7	X	X
0,25				X
0,3	1.273	2,2	X	X
0,4	1.135	2,4	X	X
0,5	1.130	2,7	X	X
0,6	1.047	2,9	X	X
0,7	991	3,1	X	
0,8	1.022	2,7	X	

### **hardness after welding**

Ø	HRC	base material
1. layer		
2. layer		
3. layer		

(results on request)

### **Following standard:**

#### **Laser welding wires**

rods: 333 mm / 1.000 mm

spool: K80 / K125 / K250 / SH253 / MA125

The reported values were determined by the manufacturer and / or by a neutral  
Laboratory determined. For the accuracy we can not guarantee)