Data sheet

QuFe10

DIN EN ISO 21952-A: G/W MoSi ; AWS A5.28: ER70S-A1 (M.-No.1.5424)

is chosen for changing and repairing shaped cavities in hardened materials 1.2311, 1.2312,1.2162, 1.2738, 1.2764 and 1.2767.

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

Recommendation for basic materials

1.2311, 1.2312, 1.2162, 1.2738, 1.2764, 1.2767
15Mo3, 16Mo3, 19Mn6, 17 Mn 14, WStE255 bis WStE460, HI, HII, GS-22 Mo 4
AWS5.28: ER80S-D2

Rework

The weld can be eroded, structured, polished, chrome-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

Inert gas	Argon	Values of the pure weld metal
Temperature	20°C	
Yield strength Re	N/mm²	>460
Tensile strength Rm	N/mm²	>530
Elongation A (Lo = 5do)	%	>20
Hardness untreated	HRC	28 - 37

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.
We cannot guarantee for the accuracy.