

QuFe60

DIN EN 14700: S Fe 4; AWS(AISI J438b) : M7 ; DIN 855: MSG4-60 – S; M.- No.: 1.3348

is used for build-up and repair welding on new parts and repairs of cutting tools, e.g. drills, milling tools, reamers, lathe chisels and cutting tools. Furthermore suitable for hard-facing on tool parts and edges vulnerable to wear. Pre-heating is recommended, the first layer is free from cracks even on critical steels.

Possible Hardness: 58 - 63 HRC
Dependent on layers and adaption

Recommendation for

Specially suitable for 1.3316, 1.3333, 1.3344, 1.3346

Rework

Material-typical treatment

Material analysis in %

C	Si	Mn	Cr	Mo	W	V	Fe
1,00	0,30	0,4	4,00	8,30	1,90	1,80	Rest

(test certificates upon request.)

Standard/Mechanical Values

Inert gas	Argon	Values of the pure weld metal
Temperature	20°C	
Yield strength Re	MPa	
Tensile strength Rm	MPa	
Elongation A (Lo = 5do)	%	
Hardness untreated	HB	58 - 63

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.