

QuFe10Cr

EN ISO 21952-A G/W CrMo1Si ; AWS A5.28: ~ER80-SB2 /ER80 S-G (M.-No. 1.7339)

is preferred for changes to and repairs of mould cavities made from tempered materials 1.2311, 1.2312, 1.2162, 1.2738, 1.2764 and 1.2767.

The Cr-content in the weld increases the tensile strength, cutting edge quality and the resistance to wear. Can be used in the long-term range for operating temperatures up to 570°C.

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

Recommendation for

1.2311, 1.2312, 1.2162, 1.2738, 1.2764; 1.2767
25CrMo4, 13CrMo 4 4, GS-17 CrMo5 5, 42CrMo4,
AIS4130, AISI4140

Rework

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

Material analysis in %

C	Si	Mo	Mn	Cr	Fe
0,1	0,5	0,5	0,8	1,2	Rest

(test certificates upon request.)

Standard / Mechanical values

Inert gas	Argon	Values of the pure weld metal
Temperature	20°C	
Yield strength Re	N/mm ²	>480
Tensile strength Rm	N/mm ²	>570
Elongation A (Lo = 5do)	%	>22
Hardness untreated	HRC	27 - 38

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.