Data sheet

QuFe15

EN ISO 21952-A G/W CrMo 2 Si; AWS SFA-5.28 ER90 S-B3; (M.-No.: 1.7384)

is preferred for changes to and repairs of mould cavities made of tempered materials 1.2311,1.2312,1.2162, 1.2738, 1.2764 and 1.2767. It is option to Fe10/Fe10Cr/Fe10NiMo because of different reactions to etching medium/acids.

Possible Hardness: 28 - 37 HRC.
According to working.

Recommendation for

1.2311, 1.2312, 1.2162, 1.2738, 1.2764, 1.2767
10 CrMo 9 10, GS – 12 CrMo 9 10 and similar

Rework

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

Material analysis in %

C	Si	Cr	Mn	Mo	Fe
0,1	0,6	2,2	1,0	0,95	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	640
Elongation A (Lo = 5do)	%	22
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.