

QuFe14

DIN EN ISO 21952-A: G/W CrMo5Si; AWS 5.9 ER502; A.28-96:ER80S-B6; M.-No.: 1.7373

is suitable for build-up and joint welding and repairs to warm working tools made from non-alloy or low-alloy steels. The weld can be used up to temperatures of 600°C. High resistance to corrosive mediums. A suitable alternative to Fe13 when a lower C-content and a higher Cr-content, is required. First layer hardness up to approx. 43 HRC, according to working.

Recommendation for

1.2082, 1.2083, 1.2343, 1.2344, 1.2367, 1.2606, 12 CrMo 19 5

Rework

The weld can be annealed, nitrated, chrome-plated, CVD plated, polished and machined.

Material analysis in %

C	Si	Mn	Mo	Cr	Fe
0,06	0,4	0,3	0,5	5,3	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	500
Tensile strength Rm	N/mm ²	600
Elongation A (Lo = 5do)	%	>18
Hardness untreated	HRC	33 - 43

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.