

## QuLPA-Fe60

~DIN EN 14700: S Fe 4; ~AWS (AISI J438b) : M7; DIN 855: MSG4-60 – S; ~M.- No.: 1.3343

Is used for build-up and repair welds on new and re-mewed tools, e.g. drills, milling tools, broaches, lathe-chisels and cutting tools. Furthermore it is suitable for armouring tool parts and edges prone to wear. Pre-heating is recommended also on very critical steels it is crack free on the first layer.

Corn size 45 – 150 µm

Reachable hardness values lie around 58 - 63 HRC.  
Dependant on working and weld layers.

### **Recommended for base materials**

Especially suitable for 1.3316, 1.3333, 1.3344, 1.3346

### **Rework**

Typical for the material

### **Material analysis in %**

C	Si	Mn	Cr	Mo	Fe	V	W
1,00	0,30	0,35	4,25	5,0	Rest	2,00	6,20

(Test certificates upon request.)

### **Mechanical Properties**

Inert gas	Argon	Values of the pure weld
Temperature	20°C	
Yield point Re	MPa	
Tensile strength Rm	MPa	
Elongation A (Lo = 5do)	%	
Untreated hardness	HRC	58 - 63

### **Delivery form:**

Plastic bottle with 5 kg in a packaging of 20 kg

The reported values were determined by the manufacturer and / or by a neutral Laboratory.  
We cannot guarantee for the accuracy.