

QuFe47

(M.-No. special alloy)

is mainly used for the repairing and building up of cast iron containing spheroidal graphite.

The weld is crack resistant even after multilayer welding. Resistant against impact loading on edges and corners. The weld can be worked without having a buffer layer.

The attainable hardness in the 2 layer is around 55 HRC.

Hardness values lie between 54 - 57 HRC.

Depending upon the working and welding layers.

Recommendation for basic materials

Nodular graphite cast iron

Material analysis in %

C	Si	Mn	Ni	Fe
0,3	0,8	3,4	1,9	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	HRC	54 - 57

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.