

## Qu819

(M.-No. ~1.6773) EN ISO 14700 S Fe 3, 819BS, 35NCD16

Build-up welding on resin moulds, drop-forging tools and dies.

The material has a high accuracy in dimension whilst having a high hardness and stability.

### Recommended base materials

35NCD16; 45NiCr-Mo18; 60NiCrMo11 and similar

1.2767; 1.2721

### Reworking

Typical for the material

### Material analysis in %

C	Si	Mn	Mo	Cr	Ni	Fe
0,35	0,30	0,45	0,25	1,7	3,7	Rest

(test certificates upon request.)

### Standard / Mechanical Values

Inert gas	Argon	Value of the pure weld
Temperature	20°C	
Yield point Re	N/mm <sup>2</sup>	
Tensile strength Rm	N/mm <sup>2</sup>	
Elongation A (Lo = 5do)	%	12 - 19
Untreated hardness	HRC	46 - 48

### Following standard:

#### Laser welding wires

Rod: 333 mm / 1.000 mm special lengths upon request

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.