



DIN 8555 MSG 6-60-GTZ
Werkstoffe No 1.4718

Solid Wire (MIG)

Hard facing

HW-1410

DESCRIPTION & APPLICATION

Solid, copper coated/bare MIG wire for the overlay of all Carbon Manganese steels. Also suited for the overlay of Cast Iron (over Buffer layer). Applications include rail tamping tools, hammers, percussion tools, mixing paddles, Earth moving equipment and Agricultural implements. Finish by grinding. Hardness dictated by many factors, including dilution, hardness of base material, etc.

BASE MATERIALS

All Carbon/Manganese steels, (over 307 Buffer layer if necessary),
Cast Iron (over buffer layer of Westbrook SW 55, or similar, in electrode form).

MECHANICAL PROPERTIES

N/A	N/A	N/A	580-650
UTS n/mm	YIELD 0.2%	ELONG A5%	HARDNESS HV

METAL WELD COMPOSITION %

C	Si	Mn	Cr	Ni	Fe
0.45	3.0	0.8	9.0	0.6	BAL

PACKAGING

15kg Spools (MIG)

DIAMETERS

1.0, 1.2, 1.6mm (MIG)

WELDING INSTRUCTIONS

Preheat as per the requirements of the base material. Large deposits may require a buffer layer of SW 312 or SW 307 to avoid cracking. Shielding Gas, 5% or 20% CO₂ in Argon. Set amps/volts on low side for minimum penetration.

For more details on welding of Hard-facing, please see our Information Sheets.

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