



# HSS TIG Filler Wire

Tooling (55-61HRC)

DIN 8555 WSG 4-GZ-60-S  
Werkstoffe No 1.3348

## HW-1460

### DESCRIPTION & APPLICATION

HSS TIG Filler Wire for the repair and reclamation of High Speed Steels, Cropping and Cutting Blades, Hot Shear Blades and surfacing on machine components and tools. Particularly suited for materials exposed to temperatures up to 500°C, together with abrasion, compression and erosion. May be used in the manufacture of Cutting Tools from low alloy base material. Usage includes cutting edges for guillotine blades, dies, swages and hammers.

### BASE MATERIALS

BS D2, D3, S1, 2767, W2, H13, H10, H11, O1, M2 (HSS)  
Werkstoffe Nr. 1.3316, 1.3333, 1.2767, 1.3344, 1.3346, 1.2510

### MECHANICAL PROPERTIES

N/A	N/A	N/A	~550-650
UTS n/mm	YIELD 0.2%	ELONG A5%	HARDNESS HV

### METAL WELD COMPOSITION %

<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>Cr</b>	<b>Ti</b>	<b>Mo</b>	<b>W</b>	<b>V</b>
0.9	0.5	0.3	2.5	0.6	9.1	1.8	2.0

### PACKAGING

5kg Tubes (TIG)

### DIAMETERS

1.6, 2.4, 3.2mm (TIG)

### WELDING INSTRUCTIONS

Always preheat as per the requirements of the base material. Large deposits will require a buffer layer of SW 312 or NW 1720 to avoid cracking.

**For more details on welding of Tools and Dies, please see our Information Sheets.**  
**Visit:** [www.westbrookwelding.co.uk/downloads](http://www.westbrookwelding.co.uk/downloads)

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01925 839983

[sales@westbrookwelding.co.uk](mailto:sales@westbrookwelding.co.uk)

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