

Classifications

DIN 8555	EN 14700
G 21-GF-60 G	T Fe 20

Characteristics and field of use

The filled gas welding rod WEARtig XD FeW60 is suitable for claddings on tools and machine parts subject to highest mineral wear, such as drill bits, roller bits, sets of drill-rods, excavator buckets, mixer blades. It is also suitable for highly stressed machine parts, which are used for the reprocessing of sand, cement, lime, clay, coal, slags.

UTP A 7560 is suited for extreme mineralic abrasion with medium impact strain.

Hardness

Carbide: approx. 2500 HV

Matrix: approx. 60 HRC

Typical analysis in %

W ₂ C	FeC
60.0	40.0

Welding instruction

Clean welding area to metallic bright. Preheating temperature 300 °C – 500 °C, depending on the size of the workpiece. Hold torch as flat as possible to the workpiece. Melt surface slightly. Avoid overheating.

Rod diameter x length [mm]	Current type	Shielding gas
3.5 x 700*	DC (-)	I 1
4.0 x 700*	DC (-)	I 1
6.0 x 700*	DC (-)	I 1

*available on request