

Classifications		
EN 14700	DIN 8555	Material-No.
SZ Fe 1	MSG 1-GZ-250	~1.7384

Characteristics and field of use

WEARmig Dur 250 is used for MAG buildups on structural parts subject to rolling wear and where a good machinability is required, such as rails and rail crossings, crane wheels, rollers, couplings, shafts and gear parts.

WEARmig Dur 250 has a very good resistance against compression and rolling strain. The weld metal is easily machinable.

Hardness of the pure weld deposit : approx. 250 HB

Typical analysis in %					
C	Si	Mn	Cr	Mo	Fe
0.1	0.6	1.0	2.5	1.0	Balance

Welding instruction

Machine welding area has to be metallic bright. Massive parts have to be preheated to 300 °C.

Wire diameter [mm]	Current type	Shielding gas (EN ISO 14175)		
1.2	DC (+)	M 12	M 13	M 21
1.6*	DC (+)	M 12	M 13	M 21

*available on request