



**DATA SHEET**  
**DS 066**  
**Rev. 6 dd 14/05/2015**  
**INEFIL 350**

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**CLASSIFICATION**

**APPROVALS**

AWS SPECIFICATIONS	EN SPECIFICATIONS


**ALLOY TYPE**

Copper-coated solid wire for hard-facing.

**APPLICATIONS**

Copper-coated solid wire for hard-facing suitable to restore surfaces to be subjected to abrasive wear. 350 Brinell is obtained in all weld metal conditions and it depends on material type and the number of deposited layers. A cushion layer deposited with basic-coated electrode or basic flux cored wire is essential only with hard-to-weld steels. To be used under the shield of Ar+CO<sub>2</sub>.

**MATERIALS TO BE WELDED**

ASTM	EN	Others
	(BS 4360)	
	(BS 3100)	
	(BS 1504)	
	(BS 11)	

**WELDING GUIDELINES**

Machinability by grinding wheel and possible quenching at 880°C oil, annealing at 850°C.

**TECHNICAL INFORMATION**

Gas: Mix Ar- CO<sub>2</sub> (EN ISO 14175)  
Welding positions: all positions



**WELDING PARAMETERS**

Current	DC + Reverse polarity				
	0.8	1.0	1.2	1.6	
Diameter (mm)					
Volts (V)	16 ÷ 28	17 ÷ 32	18 ÷ 34	19 ÷ 38	
Intensity (A)	60 ÷ 200	80 ÷ 260	100 ÷ 360	130 ÷ 450	



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**TYPICAL CHEMICAL COMPOSITION OF WIRE**

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	
0.07	0.50	0.40	0.010	0.010	5.80	-	0.60	-	

**TYPICAL MECHANICAL PROPERTIES**

GAS	Hardness
	(HB)
M21	~ 350

**PRODUCTS AVAILABLE**

Process	Product	Classification AWS	Classification EN
MIG/MAG Solid wire			
TIG Rods			
SAW Submerged arc			
FCAW Cored wire	INETUB MHF 450		EN 14700: T Fe2
SMAW Electrodes			