



DATA SHEET
DS 078
Rev. 1 dd 27/04/2015
INEFIL 600

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CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
	EN 14700: S Fe8

APPROVALS

ALLOY TYPE

Copper-coated solid wire for hard-facing.

APPLICATIONS

Copper-coated solid wire mostly used with semiautomatic and automatic procedures, for hard-facing wheels, rolling mill rollers tracks, sliding rollers, screws, mill crushing jaws and mill wheels, where excellent resistance to abrasion is required especially when accompanied by shocks, and blows, and for hard-facing wearing components such as excavation buckets and teeth and surfaces subject to abrasion and heavy loads. 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+CO₂.

MATERIALS TO BE WELDED

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

WELDING GUIDELINES

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

TECHNICAL INFORMATION

Gas: Mix Ar- CO₂ (EN ISO 14175)
Welding positions: all positions



WELDING PARAMETERS

Current	DC + Reverse polarity					
Diameter (mm)	1.2	1.6				
Volts (V)	19 ÷ 32	21 ÷ 34				
Intensity (A)	120 ÷ 320	140 ÷ 340				



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TYPICAL CHEMICAL COMPOSITION OF WIRE

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	V %
0.45	0.40	3.00	0.030	0.030	9.50	-	-	-	-

TYPICAL MECHANICAL PROPERTIES

GAS		Hardness
		(HRc)
M21	as welded	~ 58

PRODUCTS AVAILABLE

Process	Product	Classification AWS	Classification EN
MIG/MAG Solid wire	INEFIL 600 BR		EN 14700: S Fe8
TIG Rods	INETIG 600 BR		EN 14700: S Fe8
SAW Submerged arc			
FCAW Cored wire	INETUB MHF 600		EN 14700: T Fe8
SMAW Electrodes	INE RD 600		EN 14700: E Fe4