

5.2.2 Welding rods for tungsten inert gas welding of claddings and hardfacings

Designation	Standard	Weld Metal Analysis [Wt. %]											
capilla®	EN 14700 (DIN 8559): G Fe 10 (WSG 8-GZ-200 KPZ)	C	Mn	Si	Cr	Ni	Mo	Nb	Co	Others	Fe	SG	Hardness*)
5201 WIG		0,05	6	0,5	19	7,5	-	-	-	-	Bal.	I1	180HB/400HB**
250 WIG	S Fe 1 (WSG 1-GZ-250)	0,1	1	0,4	1	-	-	-	-	-	Bal.	I1	250 HB
300 WIG	S Fe 1 (WSG 1-GZ-300)	0,15	1,5	0,4	1	-	-	-	-	-	Bal.	I1	300 HB
600 WIG	S Fe 8 (WSG 6-GZ-60)	0,45	1	2,5	9	-	-	-	-	-	Bal.	I1	60 HRC
54 WIG	S Fe 8 (WSG 6-GZ-60 P)	0,5	0,5	2	9,5	-	-	-	-	-	Bal.	I1	58 HRC
655 WIG	S Fe 8 (WSG 6-GZ-60 GZ)	0,5	1,2	1,2	5	-	1,2	-	-	W=1,5; V=0,5	Bal.	I1	60 HRC

*) Min. values at AT / no heat treatment; shielding gas (SG) acc. EN ISO 14175;

**) strain hardening;

Dimensions: Ø 1,6; 2,0; 2,4 [mm]; length 1000mm; other dimensions and packing units on demand