



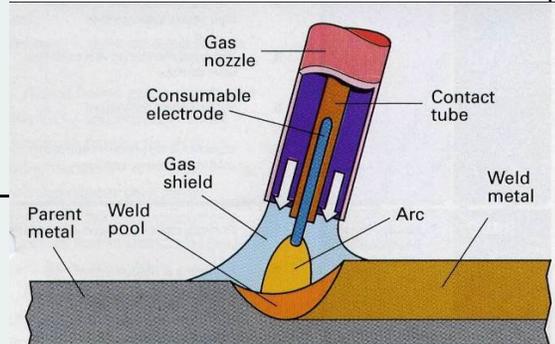
GOLD 600 –GMAW

Solid wire electrode for gas metal arc hard facing (GMAW-MIG)

Hard facing wire for overlays which must **resist impact ,pressure and abrasion.**

Typical applications are bucket edges and bucket teeth ceramic moulds, crusher rollers and cones mill hammers, cams, bulldozer blades, cutting edges, screw conveyors , grab jaws, ripper teeth, chisels ,press moulds, scrapers excavator parts, chisels truck links etc.

- Multi pass build up possible without cracks. Heat treatable deposit
- For use on steel, manganese steel, and malleable iron
- Good resistance to heat (up to 550 C) and general corrosion
- **Good abrasive wear and impact resistance**
- **Weld metal Hardness 55 -60 HRC ~**
- **obtained in 2-3 layers of pure weld metal**



| C | Si | Mn | Cr | Mo | Nb | Fe |
|---------|---------|---------|------|------|------|------|
| 0.4-0.5 | 2.8-3.2 | 0.4-0.6 | 8-10 | 0.08 | 0.02 | Bal. |

Weld metal composition (%)

Form of Delivery:

| Ø [mm] | Type of spool | package weight [kg] | Welding Parameter Pulsed arc AMP. | Welding Parameter V |
|--------|---------------|---------------------|-----------------------------------|---------------------|
| 1.0 | D/BS 300 | 15 | 80-260 | 18-28 |
| 1.2 | D/BS 300 | 15 | 140-300 | 20-33 |
| 1.6 | D/BS 300 | 15 | 200-400 | 24-36 |



Shielding Gas :

M1, M2, M3 (Argon+2-50 % CO²) C1 100 % CO₂

18-20 l/min

Attention : for build ups on hard and high alloy steel a cushion/buffer layer of ARCWEL GOLD 320 is recommended



Disclaimer:

The information and data presented herein are typical or average values. Application suggested are made solely for the purpose of illustration to enable the reader to make his own valuation and are not intended as warranties

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