

DATA SHEET

SW Hard 60 15kg/SP 1.2mm

097-003549-30012



- High-alloy solid wire electrode
- Copper-plated, layer wound
- Good wear and impact resistance
- Up to 60 HRC
- **Fields of application:**
 - Impact drill bits, cutting tools, screw conveyors, etc.

Standards	DIN EN 14700 - S Fe8											
Material number	1.4718											
Welding positions	PA / PB / PC / PD / PE / PF											
Polarity	DC+											
Ø	1.2 mm											
Chemical analysis (in %)	C	Si	Cr	Mn	P	S	Cu	Ni	Mo	Al	V	W
	0.45 %	3 %	9.3 %	0.4 %	<0.025 %	<0.02 %	<0.25 %	<0.15 %	<0.15 %	<0.03 %	<0.03 %	<0.1 %
Shielding gas	M21											
	I1											
Packing drum	B300											
Weight	15 kg											
Hardness	55 - 60 HRC											
Base materials	X45CrSi9-3 4Xr9Si2 X45CrSi8 HNV1 HNV2 SUH11 X45CrSi 9-3 401 S45 SUH 1 STR 1 40Ch9S2											